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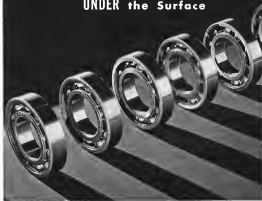
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# What an Owner Says!

## ALL METAL SPARTAN Execuliner



**Selenograph Service Corporation**  
*Kennedy Building Tulsa, Oklahoma*  
 April 10, 1952

Mr. John Tracy  
 Spartan Aircraft Company  
 Tulsa, Oklahoma

Dear Mr. Tracy:

Having just returned from a trip to New York to see the new Spartan aircraft, I am writing to you to express my appreciation for the time you have spent in showing me the new aircraft.

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## TOMORROW'S AIR TRANSPORTATION TODAY

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politics and really represent all the private pilots at once instead of making competitive membership drives. We sincerely do respect the Senate of the F.P. The National Aeronautic Association and the Private Pilot's Association seem to be fairly close together in this matter, which is all to the good. The P.F.A. has been carrying the ball for a long time under the able leadership of Bill Bendoricoff, and if he and N.A.A. RD Export can get together to settle their age-old differences of opinion they could make a strong team. Accord between other N.A.A. and P.F.A. with the third group, an organization (as yet unnamed, as far as we know) sponsored by a group of wealthy sportsmen pilots from Philadelphia, seems practically impossible at the moment. Perhaps we could make a bit more enthusiastic about the latter effort if it didn't carry the earmarks of a sponsored hunting scheme for a certain publication. It is impossible that the sponsoring group didn't see it up for what it was, for nothing could be more certain than that their own interests are only to promote private flying without expenditure of commercial gain for themselves.

READER'S DIGEST has suddenly developed a marked interest in private flying also. According to a release just received "Dwain Wallace (publisher of RDJ), and a pilot himself, decided that it would be a good thing to put a recognized authority and a plane at the disposal of any and all groups who are interested in flying." The idea seems to be to persuade the average citizen that the time is now ripe for him to fly. The authority is Roger G. Williams; the plane, a Cessna 441. The Editor's suggestion for the next couple of months is to cover New England making speeches to Congress, Senators, Chambers of Commerce, and elsewhere—also to take as many pic-

nics as possible for first rates. We don't know just what is behind this idea exactly, but it can't have anything to do with a widely read magazine as RD not promoting private flying. The most serious C.A. Williams can make, and the most difficult the Bendoricoff can take, the better.

COMPLETE WASHOUTS among new machines proposed for evaluation at Wright Field recently have been high, have hampered the Air Corps' program for modernization and expansion. It seems probable that had luck, rather than fundamental faults in the airplanes, was behind most of the accidents, but there is much cause for the only article submitted has been destroyed, how can it be proven? Which suggests a thought that is commonly accepted as good sense by other countries who are

building up their air forces and which has already been kindled at by our own high command. Why not require two or three identical samples of the prototypes to be submitted with each bid? It would be expensive, all admit, but to the manufacturer it might prove a cheap form of insurance, and it would save a lot of time that is now being irretrievably lost with each accident demanding to be considered, especially in these times.

LAST MONTH we started a new series of engineering articles by Mr. George Trickett, the second of which appears in this issue. Through oversight, we neglected to mention that these articles were based on work done by Mr. Trickett in the possession of a thesis for an A.E. Degree at New York University. However, our apology to the author and to the University.



"Steve is giving Harold a few pointers on AVIATION'S Ten Commandments for Private Pilots." (The finished job appears in page 20-21.)

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## In Combat or Commerce Confidence Counts!



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## Side Slips

By  
**ROBERT OSBORN**

**I**n The Intrepid Aviator dropped in the office the other day for his morning check-up on the quality of our pages, and along about the fifth paper mentioned that he had gotten himself into a bit of trouble with the local Civil Aeronautics Authority Inspector.

It seems that things had been somewhat slow friendly with the Intrepid Aviator lately as he had been taking in his spare time with a job delivering with the milk truck being one of those times covered by a light four-cylinder airplane engine. However, the Inspector refused to credit



time on the milk route toward maintaining his pilot's license and was particularly nervous about one item on his log book listed as blind flying when he went to work right after a party and had to locate most of his passengers merely by instinct.

**A** news item mentions that a transportation Lockheed Electra had just been delivered to the AIRPORT Air Lines of Japan, Inc. Judging entirely by the name of this company we should have thought they would be interested chiefly in the American type of "steer" plane.

**T**he limit of passengers carried in the Boeing Clipper on the job country "great flight" around New York City filed several columns in the newspapers. Many an old-time pilot was probably thinking how he would have been sitting pretty with one of those ships in the days when the barometers were still putting the dollar per passenger for short hops.

**A**rry officials are reported to be still searching for the ideal plane which could be used in the construction of the thousands of airplanes authorized by the new appropriations. One official was quoted as saying he was looking for a material with which airplanes could be "sprung out" as easily as they could be with concrete. We can't tell how where to find such a plastic but we do know where there are a couple of airplanes that fly so if they had been poured out of concrete.

**O**ne of the most remarkable demonstrations of the amazing progress of airplane design in recent years is the fact that the gross weights of our larger aircraft are now given in tons rather than in pounds, as they were only a short time ago. We didn't even bother with any automobile stages of using "tons" in "hundred-weight."

However we must face the fact that the gross weights of such individual design hasn't changed a bit since the Wright Brothers first flew. While it was being tested on the west coast the newspapers referred to the

Big Pan-American boat as the "forty-ton Clipper," in the publicity attending its delivery to the east coast it had become the "forty-one-ton shipper" and now we read that the "forty-two-ton shipper" is making survey flights across the Atlantic. If this trend in weights, size and speed is in continuation of the same pace the U.S.A. will have to work up some new engineering units for its—tons per square mile per hundred miles per hour—and in so.

**R**ecently a private plane carrying a hydroplane-tail and his last was across the country in a working at New York was forced down by weather and the group was delayed for several days. One thing led to another, it seems, and the wedding was finally called off.

A friend of mine, known to be considerably less polite, is bewailing the fact that the airplane had not reached its present stage of development at the time of his marriage.

**A** news dispatch states that after much digging according the Germans have discovered a large supply of



broken gas in a region near the Dutch border. Just for some good clean fun we think this Dutch should make application to Mr. Hitler for the concept of some of this gas to the United States.

**I**nternational Commerce Experts discuss affairs here always stated that the present trouble in Europe and the Orient is the result of an inevitable struggle between the "have war" and "have no war" nations. If this is the true cause of the difficulty it would seem that we aren't going to have to worry about Germany, Italy and Japan much longer.

**W**e certainly were busy in assuming that a inspired interest somewhere might provide us with powerful means of defense. Recent events indicate we wouldn't be secure even if we owned a whole country with a well equipped standing army plus reserves.

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Pilots of the future and of the present should profit by the methods of Paul Wilcox, of Ryan, who is puffing an STM through its paces above the clouds at a safe altitude of 10,000 ft. In his test work Pilot Wilcox climbs to 10,000 ft. before starting his routine of rolls, loops, dives, snap rolls, spins, and other acrobatics.

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## AVIATION for May, 1939 \* \* \*

### To the New Pilots of America:

The government of the United States is now making it possible for you to realize what must have been a long-pending invitation for many of you—a chance to learn to fly. To many of you it will be just the beginning of a long career in aviation, one that will undoubtedly yield you much pleasure and profit, and one which can be of considerable benefit to the country.

Most of you look upon this new opportunity as a privilege—and properly. But you must realize also that it entails considerable responsibility. There is more to it than just your own work. The success or failure of the government's training program will depend on a large degree upon how seriously you look upon your part of it, and especially upon the elimination of all shortcomings and neglects which might lead to unfortunate accidents. There is no doubt that public opinion will be aroused to oppose the continuation of the training program if any undue number of accidents occur.

And accidents need not occur. "Accidents" don't happen—they are caused. Our designers and manufacturers have turned out the finest airplanes in the

world for you to fly. The C.A.A. is taking every precaution through selection and inspection to insure that the equipment is airworthy and maintained in safe operating condition. The instructions with which you work are tested and selected for their safe operating methods. Much, then, will depend on how you yourself behave, both during the dual instruction period and in the solo hours that follow.

No one can hope to give you a complete set of specific rules covering how you should act under every circumstance, but out of the combined experience of many others who have gone through the period of training on which you are now embarking, has come a set of general principles that you would do well to put in your cockpit. If you like, you can call it a condensed version of the Ten Commandments, for if you follow them religiously you will live to enjoy your earthly wings for many years.

These rules are simple, but if you follow them carefully you will very seldom get into trouble.

Good luck, and best wishes for many useful years in this interesting new job of yours.

Sincerely yours,  
THE EDITORS OF AVIATION

**I. DON'T SHOW OFF.** Zooming over your girl's house, or turning to wave good-bye to her as a take-off is an easy way to terminate your romance suddenly.

**II. KNOW YOUR LIMITATIONS.** Don't try to perform the impossible with yourself or your ship. Don't be afraid to take a little extra time to check yourself out on a strange ship. Especially, find out when it spins, and why, so you won't be surprised some day.

**III. DON'T TAKE THINGS FOR GRANTED.** No one will resent it if you personally check your fuel or your controls before take-off. It is the mark of a good pilot.

**IV. GET AWAY FROM HOME.** You may know your own airport well enough, but making practice landings in strange airports is a good form of insurance. As soon as you are qualified, get all the cross-country you can. Learn to look for other wind indicators than a windsock.

**V. WATCH YOUR WEATHER.** Even the best of the air line pilots spend a lot of time look-

ing at weather maps and flight conditions before every take-off. Stay on the ground when things look doubtful.

**VI. STUDY THE REGULATIONS.** Become familiar with the rules that have been drafted for your safety and obey the intent as well as the letter of the law. Most accidents can be traced to violations.

**VII. CHOOSE YOUR FRIENDS.** Especially when it comes to listening to hangar flying stories. A lot of flying tests you hear from the old-timers were happened anyway, and besides, possibly someone may be pulling your leg.

**VIII. THINK AHEAD.** Take time out to consider all possible things that may happen to you and decide in advance just what you will do under all circumstances.

**IX. SET A GOOD EXAMPLE.** You may be young at this business, but remember there are those younger who look to you for guidance.

**X. FLY HIGH—FLY FAST—KEEP YOUR NOSE DOWN ON TURNS!**

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**By Melvin N. Gough**

*Former Test Pilot  
National Advisory Committee for Aeronautics*

## The TEST PILOT looks at **AIRCRAFT SAFETY**



**I**f aviation is to come into its own — to be used by the masses for private operation and to occupy a position of public utility comparable with that of the automobile—safety must be given main preeminence. It is hoped that this emphasis can be given to safety with a minimum handicap to performance but, regardless of the cost in that respect, if aircraft are to be made safer for the average person, improvements in design must be effected which will reduce the regulation and efficiency now imposed on the operator and, by the simplification of duties and the improvement of working conditions, eliminate the physical and mental fatigue with which their operation is now associated. There is no doubt that many such improvements can be made.

The Federal Aviation Commission and its successor, the Civil Aeronautics Authority, have done all in their power to set minimum standards of performance and flying qualities that are reasonably necessary to insure a

fair degree of safety. They recognize the practical reward as safety attached to exceeding the standards as set. But an attempt is made to be as tolerant as possible. What happens, however, is that the desire for greater load-carrying capabilities or increased performance on the high-speed end of the flying range causes an undue very loose design for further tolerance in these standards. Very often are the applications of new lighter designs and to increase safety by further reduction of minimum speed. The minimum is kept as it was and the top speed is increased. And, again, self-defense, if it is most thought given to stability and control characteristics that just enough to meet the minimum requirements set.

Such progress in aviation can be made only by the expense of safety. Therefore, it has not been entirely clear to us how that result could be accomplished, and it still is not clear. Designers have surprisingly little information on which to

base their design. Accurate estimates of performance can be made, but flight characteristics are more a matter of chance. Practically all existing data on flight characteristics, and by that is meant the behavior of an airplane under defined controls or external disturbances, are of a qualitative nature. There is need for more specific knowledge. It resulted for E. P. Warner to suggest the evaluation of flying qualities on an actual numerical basis in hope that by so doing a uniformity of opinion on the part of the operators and pilots as to what constitutes good characteristics and safe flight operations might be obtained. This might not characteristics be designed for and these evaluations determined.

The National Advisory Committee for Aeronautics at its Langley Field headquarters made a study of Mr. Warner's proposal and prepared a general program of measurable flying qualities and of the tests by which they could be studied. Consideration was given to the diffusion of the flying qualities in terms of factors known to be susceptible of measurement by creating N. A. C. A. instruments. Consideration was also given to the possibility of making the measurements with standard aircraft instruments.

Largely under the direction of Paul E. Wick, formerly of the Laboratory staff, qualitative studies of specific control and stability problems had been made for many years and, in

many cases, specific measurements were made from which quantitative data were obtained and to attempt made to evaluate desirable and undesirable characteristics in specific conditions. But for the first time an attempt was to be made to measure the manner in which many characteristics grouped together assessed themselves in a complete airplane design. The

is not required in keeping them from oversteering. In addition, all types, excepting possibly subsonic which are rarely not recognized as a particularly safe means of transportation, are susceptible naturally to vertical displacement.

As regarding pitching errors, it would seem that the first accident which occurred to a new type airplane might

well be the the direction of the roll due to accompanying adverse action yaw when the elevator was increased to the extent of stability. Owing to large variations in acceptable stability, it is hardly to be expected that any one but specialists of stability and control will be found. Plans will, in general, take all the control they can get. It is not possible that in many respects designers, and do, get entirely too much?

Controls are added by the laws required to operate them and the response produced. In addition, a vehicle, which is light, free of friction, has no small inertia, requires an application with definition and forward speed, and, in addition, a profile, with no lag or delay, a response that varies smoothly and linearly with displacement have been found to be both pleasant to operate and desirable. Such controls build confidence. There is a certain logic in these operations. Precision and errorlessness are responsible for the lack of self-oscillation and then, in effect, reduce stability. That should also be a certain necessity in the response of the control effort required on the part of the pilot to operate the various controls. For instance, controls of the movement of the elevator, the ailerons, the rudder, for their operation if the losses to operate them in normal flight are approximately in the ratio of 1:10 for the ailerons, elevator, and rudder, respectively.

Powerful lateral control is desirable for maneuverability. There is an increasing requirement for lateral control with greater response and that the new era, accompanied by an eye. It is inherent in present types of aircraft that the response down to the extremes in speed. These new types to be sufficient control at low speed and high speeds while there is almost always a mental loss of control beyond maximum lift. Even if the controls were very improved, however, experience has shown them generally to be in the way of the pilot if violent maneuvering is required.

Reduction in lateral control at high speed due to limited deflection caused by side strength has also been found objectionable.

(This is page 88)

**Some thoughts on controllability and maneuverability from the pilot's point of view—not necessarily conclusive, but certainly worthwhile as they stem from the author's experience as N.A.C.A. Senior Test Pilot. His job has involved many hours flying on many types and sizes of airplanes.\***

Available instruments, all of which could be synchronized with time and personal observation, measured air speed, control disposition, and airplane motion and attitude, as defined by velocity and acceleration along and about the three major axes and airplane axis. Already, tests have been made on seven airplanes ranging in size from 4,000 to 70,000 pounds and having from one to four motors. Although the quantitative data on these specific airplanes are considered confidential and are not yet available for publication, the maximum and conservative nature of the test procedure has resulted in additional pitfall experience and, it is believed, allows a more definite expression and has been made possible regarding many of the known desirable and undesirable stability and control characteristics of modern airplanes. The unusual opportunity has existed for close cooperation between designers and pilots to obtain a mutual understanding of exactly what can take place both qualitatively and quantitatively.

In a comparison of the basic safety of air transportation with the safety of other means of transportation with regard to stability and control, one should pick out the strong points of the other forms of transportation. Surface vessels and land-based vehicles have a very large inherent capacity to remain right-side up. Under normal conditions and in bad weather and fog, the retention of the operator

is found to have occurred due to a so-called error in judgment on the part of the pilot and improper operation of the airplane. But when the second or third accident occurs, this same loss of the human being can no longer be charged with the accident. It becomes a designer's error. One of the first questions asked in an investigation of accidents in industry, railroads, or steam vessels, is: "What happened to the safety device?" or "What safety device could be applied to keep a repetition down?" The application of a similar thought to aviation in the instance of the C. A. A. in their quest for built-in safety. The important point is how can accidents be prevented and not who is at fault.

### **Lateral Control and Stability**

One of the most important factors governing safety in good control. It is reasonable to expect that an airplane shall be easy and simple to control under all conditions of flight. Control and stability, major factors affecting maneuverability, are closely related. They are no more easily separated in discussion than in flight. An aircraft control system which is perfectly sound when used as a wing with no lateral angle actually produced, flat, no roll and then a con-

\*A paper presented for the symposium on "The Pilot's Ability" Committee of the N.A.C.A. held at the 7th Indianapolis, June 10, 1931.

# RESEARCH

Scientists said more that Britain's wars were decided not on the field of battle but on the playing fields of Rome. With equal certainty we can say that wars between the great air powers in the future are now being decided at the wind tunnels, towing tanks and engine laboratories of the aeronautical research centers of the world. The evidence is already in sight. It can be seen in the calculations that those countries who are now making the strongest bid for national supremacy through the threatened application of uncontrolled use of air power are the ones that have undertaken the most intensive and the most extensive development of their aeronautical research facilities in the past few years.

In the course of two recent trips abroad AVIATION's editor has had opportunity to visit many of the great aeronautical research centers in Europe, including Britain's National Physical Laboratory at Teddington and the Royal Aeronautical Establishment at Farnborough; Germany's great research center at Adlershof, the French experimental ground at Villaroche; and the aeronautical city of Göttingen near Rome. To such first-hand evidence has been added the experiences of other observers and recourse to recent progress reports from abroad. Out of it all emerges a very suggestive composite picture.

The Deutsche Versuchsanstalt für Luftfahrt at Adlershof (Berlin) has the many years conducted an efficient research program. An excellent summary of the scope of the experimental work undertaken by the DVL was presented by its director, Dr. H. Sessels, before the Royal Aeronautical Society in London last November. The equipment at Adlershof is on a par with that of our own NACA at Langley Field, except that no full-scale wind-tunnel equipment had been supplied up to this year. Reports indicate, however, that a full-scale model project is probably under way. In the last two years additional equipment has been added to the Adlershof wind-tunnel facilities including a very high speed wind tunnel (reported to have 17,000 hp. installed), to provide a maximum air speed of just over 500 ft. per second in a test section approximately 12 in. in diameter), a large laboratory for static and vibration tests on airplane structure, and high altitude test equipment for engines over 1,800 hp. Changes

(1) Outside nose of the largest wind tunnel at the DVL at Adlershof, (Germany).

(2) Test cell is used in the vertical spinning tunnel at Adlershof. This tunnel is now accepted in operation at three atmospheric conditions.

(3) Experimental section of an open throat tunnel of the DVL. Note that balance and model are on a traveling platform.



# WINS WARS!

Victory or defeat in the coming struggle for air supremacy on international trade routes or in military campaigns is now being measured out in aeronautical laboratories.

have also been reported in the vertical spinning tunnel so that it may now operate at pressures up to three atmospheres.

But equipment is not everything. It takes trained men to staff a world-wide aeronautical research laboratory. It is known that the personnel of the DVL at Adlershof numbers the Langley Field group by four to one, and the DVL is only one of five major research stations now operating in Germany. In fact, the total German research organization is estimated to be between six and eight times the size of that of the United States. It is known that certain large universities in Germany are conducting considerable experimental work on aircraft and engines and are at the same time turning out trained technicians for aeronautical research in large numbers. Italy is close on the heels of her own partner in quality of research if not in magnitude. The research city of Göttingen with its high speed towing tank, its battery of quadruple wind tunnels, and its new supersonic tunnel makes an impressive showing to the American visitor. It is no accident that Italy has captured a large share of the world's speed, altitude and endurance records, or that she possesses surplus and engine whose efficiency ranks close to the top in Europe today. The answer may be found within the walls of Göttingen.

Although Japan will probably never be a leader in research, certain of her scientific men have made notable contributions in the field of aerodynamics and it is known that her research activities are being expanded markedly. But there is little doubt that her aircraft will continue to improve at a rapid rate so long as she is in a position to profit by the political partnership with Germany and Italy by drawing on the research facilities at Adlershof and at Göttingen.

Around Russia we know little enough—but there is ample evidence that extensive research programs are continuing.

(Turn to page 26)

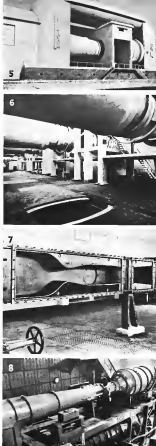
(4) Aeronautical research at the Technische Hochschule center in Hannover, (Germany).

(5) The two test double return tunnel at Göttingen. Test section may be completely closed by a sliding door.

(6) Battery of four closed-circuit test benches at Göttingen.

(7) Test section of Italy's supersonic tunnel. Air speeds up to 17 times the speed of sound may be obtained.

(8) Even the Japanese are intensively improving their research. (Continued)



## Machine Shop at Vultec

But assemblies are brought together at this assembly center in the Vultec plant.

To liquidate the heavy machine tool equipment investment in an efficient industry, the machines must be used nearly 24 hours a day. Here are a number of ingenious set-ups and techniques devised by Vultec engineers to make a single machine do many different jobs.

By Don L. Carroll

In aircraft machine work, there are two major deviations from more conventional machine work. The first is the almost universal use of light alloys of aluminum and magnesium. The second is the relatively greater loads of the parts being machined. The materials involved contribute largely to stresses and stresses, although a department has been developed for the testing and proofing of stress loads; this will be discussed in more detail later. We also have our share of steel and bronze machine work, especially in connection with heavily stressed parts such as the landing gear and steering systems. Furthermore, a rather large percentage of

our work is done on rolling airshafts rather than on lathes. Therefore, some of our more difficult problems have been in connection with tool set-ups.

One of the first things we learned when we undertook machine production of a wide variety of aircraft parts, was that a relatively few machines could be made available for as many jobs as possible. This is contrasted from the standpoint of our contract, because an airplane factory custom built up under an individual contract. Machines could represent a relatively heavy investment and they must be kept working 24 hours a day if feasible, to retire the investment as quickly as possible. Therefore, we have developed a great many ingenious fixturs and set-ups to accomplish the triple purpose of producing the best possible work doing

it efficiently, and keeping all of our machines busy at all times.

Our machine work is divided generally into two classes, structural and operations. The structural work usually involves milling and drilling operations primarily. The operative work concerns rotating systems, control systems, etc. The latter class of work is rather conventional, involving gears, shafts, linkages, etc., and does not cause nearly as much trouble as the structural work. This is due primarily to the fact that the structural parts are usually larger and more difficult to handle, and probably because most of the structural tolerances are rigid and absolute, as is the case of holes drilled in the power's end block casing, which is a large ring segment with a diameter of approximately 26 in. It is necessary to drill 12 holes in this segment, at various points along its rim, and all of them must be drilled to a common center. These holes must also be drilled to close tolerances. To do that job we have developed a swinging fixture which is attached to the table of a Cincinnati horizontal miller. The fixture is indexed for location of the holes and the drilling and reaming is done with tools mounted on the mill shaft. We also use an end mill set-up for this same part, in order to drill the large holes in the bracket at each end of the casing. These holes accommodate the support holes for the machine gunner's adjustable seat and must be held to close tolerances on location and diameter.

A similar problem is not in drilling and milling the gun ring mount. This is a big segment, slightly larger than the gunner's seat ring, and is quite complicated inasmuch as it is mated into the plant as a single extruded channel of approximately

16mm cross section. This channel is cut to length and is then milled to form a proper seat in the Vultec rolling machine. It is then given a crude diameter cut on the outside diameter by means of a special setup on a profiling machine. This work is held to a tolerance of 0.002 in. The part is then delivered to the machine shop and there we drill 12 upper holes for mounting roller supports. These holes must be drilled to a common



Set up for boring the male side support holes in the gunmount casing for the Vultec rolling machine.



Boring, reaming and boring a hole in a hole frame casing in part of the side roller assembly.



The slotted casing for the male ring frame casing is drilled symmetrically in a position jig and then reamed to close tolerances.

center and are mated to an extremely tight. For this work we use a swinging fixture on a Cincinnati horizontal miller, very similar to the set-up used for drilling the machine-gunner's seat ring. The male shape of the ring can then mated at each end in another mill set-up in order to provide for bracket clearance at the points of attachment to the gunner's seat ring.

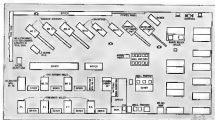
(Continued on page 46)

A swinging fixture for drilling and reaming upper holes in a common center and for milling bracket clearance on the female side in one set-up small series.



The first of two sides produced by the Vultec rolling machine. The first of two sides produced by the Vultec rolling machine. The first of two sides produced by the Vultec rolling machine. The first of two sides produced by the Vultec rolling machine.

AVIATION  
May 1952  
21



4000 sq. ft. of a steel plant floor area of 20,000 sq. ft. is occupied by the Vultec machine shop. Many fixtures and set-ups keep a relatively few machines in constant operation.



Safe method of modifying clay form from which a plastic pattern is cast to obtain precision dies. Fig. 4

## Stacks and Rings

The design and installation of exhaust manifolds and their accessories

The second of three articles.

### Part II—Expansion Joints

An exhaust system goes through many rapid changes in temperature while a engine runs below 17° F. to as high as 1500° F. It is necessary in the design to provide for the expansion and contraction of the individual parts as well as the whole system. Satisfactory results are obtained if an expansion joint is placed in the main collector ring between each cylinder in a single-row engine, or between each pair of cylinders in a two-row engine.

Expansion joints must be relatively gas tight but free enough to permit easy sliding when the exhaust is hot. Three types of joints are shown in Figs. 5, 6 and 7 (pages 56 and 58). A clearance of 0.010 inch is maintained between the expansion sleeve and the main exhaust collector ring. This clearance disappears when the exhaust is hot and relatively little gas escapes.

To permit proper servicing of the engine, easy replacement of sections of the exhaust collector ring, and free-

dom from structure before the following joints should be taken into consideration in the design of an exhaust collector.

1. Removal.—It is frequently necessary to replace one section of an exhaust collector, or to pull one cylinder

of an engine. Considerable time and labor can be saved if the construction of the collector permits the removal of one section. The type of expansion sleeve shown in Figs. 6 and 7 permits such removal. (It is advised the exhaust cover incorporate a

Continued from page 55



Fig. 15. Exhaust manifold for P & W R-1530 engine. Note the gradually increasing diameter of the main collector.

cheap type joint such as shown in the accompanying photographs the removal of one section is further simplified.

2. Interchangeability.—The manufacture of all parts of an exhaust collector should be rigid to insure easy fitting of replacement parts. Tubular parts can be bent by specialists in tube bending to exacting dimensions. Parts fabricated from sheet can be stamped out or pressed in the desired shape. One method of obtaining an accurate pattern for it is shown in Fig. 8. For welding parts a very substantial jig is necessary to prevent distortion of the work. In this connection it is advisable for the welding jig to duplicate the exhaust part loca-

tions on the engine so that the mounting flanges can be welded in place with the expansion joint not be necessary to strain them when installing the collector on the engine.

3. Expansion.—The size, fit and method of providing ground expansion joints is explained under the sub-heading "Expansion" above. Examination of Figs. 1 and 2 of the previous article will show, however, that an expansion joint is incorporated between the last two cylinders adjacent to the outlet. It is advisable to have one exhaust collector secure the last section of collector ring. Since no flexibility is provided under spring action conditions of expansion and vibration there will be a



Continued from page 55

Fig. 16. Exhaust manifold for P & W R-1530 engine. Note expansion joint and position and shape of the collector expansion.

Continued from page 55

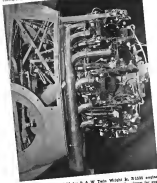


Fig. 5. Exhaust manifold for P & W Turbo-Wright R-1530 engine. Note how the collector has open slots built for collector heat sink. Note also the clamp bar which permits last portion of collector ring.

likelihood for cracks to occur at the welded intersection of the elbows and ring. It is possible to overcome this weakness by welding reinforcing gussets across the critical areas. An alternative method is to put an expansion joint between the last two cylinders and install an auxiliary flange to help support the last section of the collector ring. A clamp brace of this type can be seen in Fig. 9.

4. Vibration.—Aircraft engines usually have one or more critical vibration periods in the normal operating range. If exhaust systems have long overhangs, or are improperly supported, or are carrying welding stresses, the vibration of the engine will soon cause cracking. The use of right type clamps as shown in Fig. 9, referred to in the previous paragraph, is an excellent way to brace the collector against vibration. The inherent end of the clamps should be secured to the engine mounting lugs or other points that will move with the engine so it rotates slightly in its rubber mounting.

#### Weight

In the design of successful aircraft it is assumed that the weight of all equipment parts and accessories be kept as low as possible commensurate with satisfactory operation. Exhaust

(To be in page 56)

Based on a thesis submitted to the Office of Engineering, New York University, New York.

# STINSON 105

A three-place Cabin Ship with 75-hp. Continental Engine for \$2995

Everette has realized the need for an inexpensive airplane to be used as the next step above the present light plane class and Stinson has set about to satisfy this demand. The result is the Stinson 105 which, powered by the 75 hp. Continental engine, sells for \$2995. Fuel consumption is 4.5 gallons per hr. at about 20 miles to the gallon. Cruising speed is given as 165 m.p.h., high speed, 115 m.p.h.

Model 105 follows regular Stinson practice in that it is a high wing, semi-cantilever monoplane. Square spars, pressed metal ribs, steel drag truss and tie rods and metal struts are used in the structure. A metal covered leading edge and fabric covering are used. Adapters are built up of a steel square tube and metal ribs. Sideshells are unitarily and aerodynamically balanced. All flaps are fixed with ball bearings. NACA, slotted type trailing edge flaps extend from ailerons to the fuselage and are adjustable to three positions. They may be used for lift-off as well as landing, and are operated by a lever between the pilot and copilot seats. Ball-in cone control over 30 per cent of the aileron span to increase lateral control at high angles of attack.

The cantilever stabilizer is built up of square tubes and ribs and covered with phenolic sheet plywood. Elevators are continuous and built of metal ribs attached to a steel torque tube and are covered with fabric. One elevator has a tab. Wheel bearings are steel in the bogies.

Steel tube spars and ribs are used in the construction of the lateral, cantilever fuselage. The fuselage is of steel tube construction with fabric covering. It is mounted on ball bearing bogies. The elevator tab is adjustable on the ground.

A welded steel tube cross base fuselage structure covered with fabric, is used. The non-adjustable engine mounting is attached by rubber vibration dampers. The structure and floor will withstand adverse heat and noise on the rear fuselage. Doors are provided on each side of the fuselage.

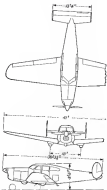
When the cabin was fitted a comfortable cantilevered rudder. Adjustable pilot's seats and the fixed seat in the rear are upholstered with tobacco brown Bonale fabric. Backs and sides of pilot's seats are finished in three-

(Turn to page 11)



Dimensions		
Wing Span	35 ft. 0 in.	107 ft. 0 in.
Wing Area	1,100 sq. ft.	
Wing Loading	11.5 lb./sq. ft.	
Wing Tip	10 ft. 0 in.	
Wing Root	10 ft. 0 in.	
Wing Tip	10 ft. 0 in.	
Wing Root	10 ft. 0 in.	

Performance		
Maximum Speed	115 m.p.h.	
Cruising Speed	105 m.p.h.	
Rate of Climb (5000 ft.)	1,000 ft./min.	
Service Ceiling (5000 ft.)	10,000 ft.	
Endurance	200 mi.	
Range	200 mi.	



# The Unitwin VEGA

A new approach to the private transport problem

By Mac Short

President, Vega Airplane Company

vised by Mr. Bill Hibbard, chief engineer of the Lockheed Aircraft Corp., who suggested mounting two engines to a single propeller through two-shafting drive shafts. The same idea was, to designate such a powerplant, was suggested by Mr. Robert E. Gross, president of Lockheed Aircraft Corp. The actual engine used was developed by the Vemco Manufacturing Company, around two of their C65-4 engines. These engines are six cylinders in line and cooled inverted engine, developing 200 hp each at take-off to give a total horsepower output for the two engines of 400 hp at take-off.

Original test work at the Vemco plant was performed on two Wright Cycle engines, which served to prove the principle of operation thoroughly. Part of this program was accomplished with the Unitwin mounted in a modified Lockheed Altair plane. This plane has been taken off under full load with unit engine rotating from a standing start, and has then been climbed to 17,000 ft on the one engine.

While the engine development program was in progress, Vega engineers conducted extensive aerodynamic analyses and wind tunnel testing, in comparing the proposed Unitwin powerplant with the conventional layout using two engines mounted in wing nacelles. The results of this design study were in every way favorable to design A, with Unitwin powerplant as compared with design B, with conventional engine installation.

On an analysis of aerodynamic efficiency, we got the following results:

## 1. Airplane drag.

Suppose the two airplanes of Types A and B have the same fuselage con-



Mac Short who presents his views on a novel design

sectional area and the same wing chord. The differences in drag will then be due to: (a) nacelle drag, (b) propeller drag, and (c) engine drag. The effect of the propeller is to add from 6 to 18 per cent to the drag of a body lying in the slipstream. Cooling requires from 6 to 12 per cent of the total power output, depending on the method of cooling system, and three efficiency. A 10-hp propeller is assumed for the Unitwin, and two 6-hp propellers for the conventional arrangement, with 50-ft wing span in both cases.

Now if D equals drag of the airplane without nacelles, propellers, or cooling and 3D equals drag of the wing, or approximately 90D per foot of span. 4D equals the drag of nacelles and 1D equals the drag of tail,

then we get the following:

Type A Unitwin		
Fuselage drag	1.68 x 4D equals	6.72D
Wing or spanwise	50 x 1.58 x 4D	316D
Wing out of slipstream	40 x 4D equals	160D
Nacelle drag	20 x 4D equals	80D
Engine	12 x 4D equals	48D
Tail drag	1 x 4D equals	4D
Total drag	1 x 40D	514D

Thus we find Type A (Unitwin powerplant) to show about 6 per cent less drag than type B.

## 2. Wing lift.

The ability of a wing to reach a high speed of attack without stalling depends on its maximum lifting power,

Type B Conventional two-engine		
Fuselage drag	1.68 x 4D equals	6.72D
Wing or spanwise	50 x 1.58 x 4D	316D
Wing out of slipstream	40 x 4D equals	160D
Nacelle drag	20 x 4D equals	80D
Engine	12 x 4D equals	48D
Tail drag	1 x 4D equals	4D
Total drag	1 x 40D	514D

and hence the maximum speed at which an airplane can fly and load. The addition of nacelles to a wing changes the airfoil shape, making that portion of the wing a relatively poor lifting surface, also causing flow to break away prematurely. The effect may reflect the wing's maximum lift

by 10-15 per cent, requiring additional wing area for type B to assure the same maximum speed as for type A.

## Simple engine control.

The effect of engine failure with a conventional two-engine airplane at its cruise altitude (fixed) and lift due to the two engines, and excessive drag due to the dead engine. These effects cause the airplane to bank and yaw slightly so that rudder and aileron displacements are necessary to keep the plane on a straight course. These rudder and displacements introduce further nacelle drag pains.

At the size of a twin engine design is discussed the propellers become relatively larger with respect to the wing span, the rolling and yawing moments become relatively more adverse, and greater care must be taken to insure proper single engine control. The whole effect on single-engine control may readily be demonstrated as follows, by comparing our previous Types A and B, with a larger plane, the Douglas DC-3.

## Type A airplane (Douglas)

Span	47 ft
Engine—two	500 hp each
Propeller—two	19 ft diameter each
Distance from Center Line to Thrust Line—3	

## Type B airplane (Douglas twin engine)

Span	47 ft
Engine—two	300 hp each
Propeller—two	8 ft diameter each
Distance from Center Line to Thrust Line—22 ft	

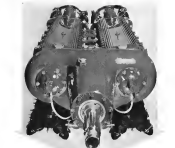
Distance from Center Line to Thrust Line Equals 71 ft, or 34 per cent of total span.

## Type C airplane (Douglas DC-3)

Span	91 ft
Engine—two	2000 hp each
Propeller—two	10 ft diameter each
Distance from Center Line to Thrust Line—22 ft	

Distance from Center Line to Thrust Line Equals 71 ft, or 34 per cent of total span.

(Turns in page 10)









See "Instruments" fold sheet with the portable WESTON ultra high frequency oscillator, also features a sheet on the volume of WEC as in the extra sheets.

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AVIATION  
May 1935



## The Background of the BARKLEY-GROW WING

By John T. Whitaker

Barkley-Grow Aircraft Corp.



THE basic problem that faces all aircraft designers is to develop a wing which will, at the same time, provide lift and carry the loads imposed upon it. Most designs embody the simple principle of a spar at least to carry the main load, surrounded by suitable structure to develop the desired shape. Although the spar may sometimes be split up into two or more elements, the basic principle remains the same.

Recently, in order to avoid the concentration of forces that normally occur the biplane design, (Barkley-Grow) attempts have been made to handle the distributed loads so they occur over the entire wing structure by making the wing itself a composite rigid or semi-rigid structure. The wings of biplanes, D. or cylindrical shaped monoplanes, stressed skin wings with internal lattices and stiffeners and other arrangements, have all been directed toward the end.

Although the cellular form of construction seemed to be the idea of long ago, a new form for the application of the principle of stress in the form of a lattice was developed by the late Sir George Phillips, the DMC-3 at (Graveside, Dorset). Followed a period of design and development during

which many wing models were made and tested in destruction. Out of it developed a design that showed considerable promise of load carrying capacity without distortion at a reasonable weight per sq ft. By 1930 work had progressed sufficiently so that a group of three business men undertook the manufacture and test of a complete wing. Results were so convincing that a complete airplane design was undertaken which has resulted in the right to use the Barkley-Grow twin-engine transport, the Model THP-1. (Aviation, February 1935)

A slight accident that occurred during the static testings of one of the wings for the transport shows immediately the ability of the wing design to "take it". The panel under test was 114 in. long with a 76 in. chord and 14 in. thickness at the root. It was tapered to 6 in. at the section and had a total area of 92 sq ft. A diagram in the test rig showed a full load of 17,000 lb. to be applied uniformly and consequently in the panel. The loading caused a final deflection of 15 in. at the wing tip. When the test had been finally reversed, the panel returned to 2 1/2 in. of its normal position at the unsupported tip.

On first sight the structure of the Barkley-Grow wing seems complicated

from a production point of view, but studies and actual shop experience have indicated that methods can be developed to produce structures of this type economically and efficiently.

Additional tests are going forward at the present time on the application of wing design in military installation. Upon completion of these tests it is hoped that we will be in a position to give to the modern of aviation a great many more industrial details of the design and production of this wing than has been possible at this time.

AVIATION  
May 1935

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Wright Cyclones power Grumman F3F-2 Fighters—the latest production model of this famous family of fighting aircraft—are now being delivered to the U. S. Navy.

Grumman Model J1F Utility Amphibians are also

powered by Wright Cyclones. A large number of these utility amphibians are serving the U. S. Navy in this country and its island possessions, performing a wide range of missions which include mapping, photography, target towing, rescue work from carriers and shore bases, and other duties.

WRIGHT AERONAUTICAL CORPORATION  
Paterson, New Jersey

A Division of Curtiss-Wright Corporation



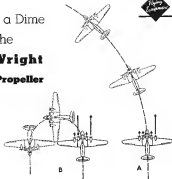
**WRIGHT** *Aircraft* **ENGINES**

Turning on a Dime  
With the  
**Curtiss-Wright**  
**Reversible Propeller**

**A** NEW ALIQUATE in propeller design has been passed with the introduction of the Curtiss-Wright reversible pitch propeller recently announced by Robert L. Earle, general manager of the Curtiss Propeller Division at Clifton, N. J. Work on this project has been carried on with the cooperation of the Navy Bureau of Aeronautics, because of the obvious value of increasing negative thrust in maneuvering large flying boats on the water.

A comparison of the water performance of a four impinged flying boat with reversible and normal propellers is shown in the accompanying diagram. The short turn at the left is made by applying reverse pitch to the two inboard props, increasing the power of the right outboard and left inboard engines, and allowing the skids to slide back on-mounted propellers (rudder) the turn is made by increasing the power of the right outboard engine and allowing the skids to slide forward. The relative amount of power applied to the props in making a turn is indicated by the length of the arrows.

Like other Curtiss propeller designs the reversible pitch type is controlled electrically. The pitch change is made very quickly, being actuated by the same voltage booster now used for that feathering. Control is by movement of the switch to the "reverse pitch" position. The output result, and warning for it, is unlike the only instant in flight. No engine cooling problem has been encountered, even at 1000 ft. The reverse pitch operation drives oil away from the engine. Indications are that the device may also prove to be of some advantage in reducing the heating rate of turbo boosters.



Turnover is best explained by using buoyancy on the water with reversible pitch propellers (left) as compared with a two mode, i.e. the use of conventional swimming (right).

## CESSNA T-50



**Telex Engine Coasts:** Flight tests are now underway on the Coasts T30, a five-place cabin ship with 2,224 hp. (four engines). A top speed of 150 mph, and a landing speed of 55 mph, are reported. Climb (first attempt) is given as 1,000 ft. and service ceiling: 11,000-15,000 ft. Gross weight is 5,000 lb.; wing area, 394 sq.ft. and area, 42 ft. Price, as yet unannounced, is in the \$20,000-\$30,000 bracket.



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The salaries of a school bus is specialized education is determined in a very serious matter. The Catholic Archbishop of Chicago has issued an fine and effort in shaping a course of study which would give the student a combination of all the work necessary to make him a competent engineer, a member pilot, and a man whose experience would permit him to enter any phase of the commercial industry with the assurance that he is truly valuable to his employer, and that his promises be sure and rapid. We had that in 1911 a man more than ready for each work, more time should be spent in the course of study.

and a wide range of animal types and production practices should be included, as well as a thorough knowledge of the pertinent economics to provide business and understanding in order to do this, the course runs 180 weeks, which is some 30 weeks longer than an engineering course is any of the leading universities offering a Bachelor of Science degree. The course extends through the summer months and is extremely intensive. It requires a tremendous amount of hard work but the results make the student in training with the assurance that the difficulty is an education of the type desired are being secured.

The internships and model facilities which accompany and make up part of such an education and which we serve, may be complete developments or merely on the way there. All model activities are supervised, and all home internships—close off students first to the campus— are of the type of which your parents will be absolutely approve. You are allowed to develop yourself with the advice supervision, and kind guidance of the camp leaders, and finally you make up a very close unit and serve as teachers and parents.

Does our Indian text include all essential? It is not necessary for the student to consider all the individual systems which generally accompany "Vedya 14 adhya." It shows that all Indian texts of the this nature.

Flight training is only offered to students enrolled in the engineering course and includes 200 hours in all types of aircraft and under all conditions. It is the most

complete course possible and produces a master plan. This course meets us with hard things and is intense with the engineering work throughout the four years.

Although World widening is not essential to the new widening to wide himself project, in summing up, it is a desirable asset and is utilized to those widening to further enhance their usefulness in the field of management. Due to the intensive nature of the course, it is impossible for a student to work part-time while attending the college, and the teachers must discourage those wishing to attend on a volunteer or fee method.

The incentive nature of the work requires that the entrance to our school house across the street. High school freshmen so we require that each student in from the top quarter of his graduating class in his senior standing. College classes start the first week in September and continue as well as follows.

## NON-REDUCIBLE

Our school is under the personal direction of His Excellency, Bishop Francis J. Shell, Auxiliary Bishop of Chicago, and founder of the nationwide Catholic Youth Organization. It is actively engaged and is one of the many enterprises in providing a lasting, worthwhile education for the youth of America. The reason is open to any and all large numbers of youth who are anxious to accomplish a lasting success through hard work and sacrifices. We cordially invite you to investigate our facilities.

## LEWIS HOLY NAME SCHOOL OF AERONAUTICS

## LOEWEN, 02/04/2011

LONG BEACH STATE SCHOOL OF ADMINISTRATION  
ADMINISTRATIVE SERVICES

More and more detailed information

Winnipeg

**References**

51

1999

*To Dads:*

If your son has a high scholastic standing and he is interested in nursing, too, make it your business now to learn more about this fine school.



### NEGATION

The effect is levying \$1 million from Chicago's Dept. 4 miles north of Indian, and approximately 1 mile from transportation to and from Chicago with railroad connections from Chicago; no other. Nothing was achieved in respect to the effect at this time.



Approved Motors Association  
Higher Powered Engines for Light  
Planes



## 60 hp. FRANKLIN

TO meet the growing need for engines of higher power in the light-plane field, the Approved Motors Corporation, of Syracuse, N. Y., has announced the new 60 hp. Franklin Model 44C-51, which holds ATC No. 306. Like its predecessor, the Franklin '30, the new '60 carries approval for use of standard 14 in. maintenance spool, plugs and a fuel system rating of 78 or better. Weight of the '60 has been kept down to 158 pounds with the single magnet. There has been no change from 23 in. to 23 in. Displacement has been increased to 171 cu. in. Overall dimensions are approximately the same as the '30 and many parts are interchangeable between the two engines. The Franklin '60 difference is a complete aluminum alloy engine, with a removable cover plate at the top for access to connecting rods and other internal parts. Three main bearings carry the crankshaft, with the third bearing designed for tractor or pusher mountings. Oil channels are drilled in the crankcase to provide pressure flow to hydraulic valve tappets, main and connecting rod bearings, camshaft bearings, valve mechanism, and other working parts. The four-chamber star-shaped alloy steel crankshaft is counterweighted as well as statically and dynamically balanced. It is also drilled for lubrication and to provide pressure lubrication to all bearings. The pusher lub service

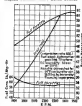
finger is forged as an integral part of the shaft, simplifying the lub assembly. The forged steel crankshaft is also drilled for lubrication. A Clevite crankshaft thrust pin connects with the steel crankshaft gear for quiet operation. Connecting rods are steel drop forgings. Pistons are cast aluminum alloy with self-lubricating piston pins, and three rings each. Cylinders and cylinder heads are cast in one piece of British "P" alloy with a nickel iron alloy type sleeve over the cylinder barrel. Each cylinder is provided with 512 square inches of heat dissipating fin area. Two combustion valves are provided per cylinder, with nickel iron alloy valve seats and guides, and two Chromalox stainless springs per valve. Valve rockers are made of aluminum with oil return to the stems and springs. Widespread hydraulic valve tappets provide automatic valve adjustment. Oil supply is carried in a wet sump crankcase, with a normal capacity of four quarts. Oil is fed through the lubrication system by a positive gear type pump. The sounding up-draft muffler is mounted directly on the crankcase with integral intake passageway cast in the cast, serving to warm the intake mixture and cool the crankcase oil.

A complete new production line has been organized at the Approved Motors plant to handle production in quantity of the Franklin '60, and a trial of 33 strategically located service

stations have been established throughout the United States, Canada, and Alaska, to insure Franklin owners of prompt and expert service.

Specifications of the Franklin "60" Aircraft Engine, Model 44C-51 as supplied by the manufacturer are:

Approved Type Certificate No.	206
Maximum rated output	60 hp. at 2500 rpm
Rated output	52 hp. at 2500 rpm
Rated speed	2500 rpm
Compression ratio	16.5 to 1
Stroke	5.5 in.
Displacement	171 cu. in.
Weight	158 lb.
Weight including oil tank	175 lb.
Fuel consumption at rated output	45.5 gal. per hr.
Oil consumption at rated output	1.5 gal. per hr.
Approved shops	Chicago, I. 40 or Schenck, N. Y. 42
Country	Germany, N. Y. 42
Diagram	See page 40



# PERFORMANCE



NORTH AMERICAN AVIATION, INC.  
LOS ANGELES MUNICIPAL AIRPORT, CALIF.



# Dependable AVIATION RADIO



**35A RECEIVER:** New, compact, light—designed for portable flying. Double action. One complete receiver covering domestic frequencies, and greater part of broadcast band as well as an transmitter receiver in one hand. Weight complete only 18 lbs.



**35A TRANSMITTER:** Designed and built specifically for portable flying. The Main Frequency Model is easy to install, simple to operate. Features on any desired power level—no aerial frequency. Made in one piece with no moving parts. For transmitter and receiver. Weight 25 lbs. complete.



**MICROPHONES:** The 421A and 421B are specially designed to operate through high wave breaks and give clear speech transmission.

...by

**Western Electric**

Under today's stricter regulations governing use of airlines and airports, two-way radio telephone is becoming as necessary to private flyers as it has always been to the airlines.

No matter what type of plane you fly, there's Western Electric equipment designed and built to meet your particular needs. It's light, compact, dependable—backed by Western Electric's years of experience in making radio telephone apparatus for the nation's major airlines and airports.

For details, write to Western Electric Co., Dept. 326 A, 195 Broadway, New York.



**HEADSET:** The 1111A, two-stroke headset is standard on most of the airline's systems. It features noise eliminator, detuning circuit.



**37A RECEIVER:** Its major signals operate on a frequency of 15 megacycles, provides for indication of cone of vision and line type when both standards are being complied on surveys. Provides indication of the ground wave and upper sections for use with automatic landing systems. Weight 11 lbs. complete for 2 frequency.

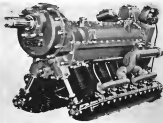


**30 TYPE RECEIVER:** Light, compact, 2 tube superheterodyne receiver with automatic volume control. Its 4 bands cover all aviation services plus the broadcast frequencies. Automatic, undistorted, tuning with control as well as hand control. Weight only 11 lbs. (10 lbs. in portable, receiver only).



**774A FILTER:** Necessary for proper reception of low modulation beams and wireless communication with power systems.

## A RANGER at 1.28 lb. per hp.



SOV-77584 has 800 hp. latest rating on 87 Octane Fuel

Introduction of the Ranger inverted V-12 air cooled engine Model SOV-77584, recently created AEC No. 202, gives America the lightest engine of this type, at 1.28 lb. per hp., in the world, and the lightest specific weight of any aircraft engine under 1800 hp., operating on 87 octane fuel. The approved take-off rating is 500 hp. on 87 octane fuel up to 1,720 ft. altitude. The normal rating of 400 hp. applies from sea level to 5,700 ft. altitude, as the engine is supercharged. A modification of previous Ranger designs, the new engine incorporates the rugged under-head cone valve operation feature, and is geared 3:2 from the crankshaft to the propeller. Proven refinements over previous designs consist of an improved type supercharger impeller, and use of steel backed copper-nickel main and connecting rod bearings. In place of the old main shaft type. Specific weight of the engine is 1.28 lb. per hp. and frontal area is only 26 sq. ft., and it is about one third that of a conventional engine of equal power. A table comparing the new Ranger with a modern European engine of similar design shows it to excel by a wide margin in power per pound of engine. The following table lists the comparative figures for the Ranger and six of the new European engines:

Engine	Model	HP	Weight (lb.)	Frontal area (sq. ft.)
Lycoming	SOV-77584	400	512	26
DeSoutter		400	512	26
Pratt		400	512	26
Pratt		400	512	26
Pratt		400	512	26
Pratt		400	512	26
Pratt		400	512	26

\* On comparison basis, but not based on a standard basis for the engine.

## LYCOMING R-680-E



The Leading Division of Aviaton Manufacturing Corporation announces the newest addition to its line of aircraft engines—the R-680-E Series engine, a six-cylinder, 800-hp. power plant incorporating many improvements.

Key including Standard Equipment

# Western Electric

Aviation Division  
of General Electric

TWO-WAY AVIATION RADIO TELEPHONE AND TELEGRAPH EQUIPMENT



**THIS EYE NEVER WINKS** at imperfection. Typical of Martin thoroughness is the use of the Electric Eye for exact electrical analysis by kilohertz, eliminating the chance for error which exists when the human eye alone is used.



**BABY GULL:** Shows in the first new sampling, Sperry, new model advanced model over built and born to perfection: the performance of a full size airplane. Types complete, the big dog (shown at right), repeated absolutely every characteristic demonstrated by the new model.



**TITAN STRENGTH:** Hundreds of tons build the 100-ton machine change drop with absolute accuracy to form sheet metal parts for Martin airplanes. Throughout the Martin factory, machinery plays a constantly forming part in speeding production.

\*\*\*\*\*

# MARTIN

AIRCRAFT

*World's Standard of*

## SKYWAY SUPREMACY

\*\*\*\*\*



### GIANT GULLS:

120 feet from wing tip to wing tip, weighing 16 tons, these are, all-around, U. S. Navy Patrol planes, with complete living accommodations for their crews, will widen the scope of action of our fleet.

(See Flying model at left)



**EXPANSION:** As this picture gives you a glimpse, construction is making an airplane into 100,000 sq. ft. factory addition. Built on a record-breaking 11-month schedule, it brings the company's total floor space to 1,007,000 sq. ft., makes it the largest single-story aircraft factory in the U. S.



**CONTRAST** the only Martin-built piston-type plane with a modern, Martin-built pilot of the class—a 40,000-pound mean transport capable of carrying passengers and payload from New York to London in less than an hour.



**OPEN SESAME:** Then, the largest vertically operated door in the world, 20 tons in weight, opens in 45 seconds, throwing open a wall area 200 feet long by 40 feet high. Inside is an assembly hall, 450 feet deep, free of pillars and other supports, large enough to handle undisturbed space for the entire assembly of planes many times larger than any yet in the air.

**MARTIN**

*Builders of Dependable Aircraft Since 1900*

# AIRCRAFT

The Glenn L. Martin Company, Baltimore, Md., U. S. A.

# AVIATION RADIO

Dialing the Air Waves with Don Fisk



## Checking Frequency

Frequency limit monitor enables checking of aircraft transceiver frequencies simple

THE REGULATIONS of the Federal Communications Commission requiring frequencies of aircraft transceivers first test be met by periodic checking of the frequency against a suitable standard. A recent announcement of the R.C.A. Aviation Radio Division in Canada is the type 203-A frequency limit monitor, suitable for frequency limit transmitters for all classes of transmitters but particularly adaptable to aircraft work. The first monitor may be used without any auxiliary apparatus provided that the transmitter output is not measured may be brought within a few feet of the monitor itself. This may be accomplished in checking transmitters which have already been installed in places. In this latter case it is possible to separate the transmitter from the monitor by as much as 300 ft., by employing a small coupling coil connected to a two coaxial cable. Such an installation may be made permanently in an airport test office with the far end of the cable clamped at a convenient position on the airport or on a hangar.

The frequency of a transmitter is actual operation, at some distance from the airport, may be checked by employing any suitable radio receiver and a low-frequency radio indicator. In this case the frequency monitor is coupled to the receiver input and the receiver is tuned to the frequency of the station to be measured. The frequency monitor provides a signal which varies with the incoming signal from the plane. The two signals produce a beat note in the loudspeaker of the receiver. The beat monitor is then used to determine the frequency of the beat note and this frequency in turn gives the frequency interval between the standard of the frequency monitor and the receiving signal. The monitor may be

used with a crystal set or an electronic set or on the second harmonic. This is particularly useful in the case of the frequency 3000 kc. and 6010 kc. The price of the radio model is \$204, that of the electronic \$294.35.

The frequency limit monitor covers a range from 1500 kc. to 45 mc. and is fitted with a lamp which lights if the transmitter frequency differs from its assigned value by more than the limit set on the dial. The frequency deviation which can be indicated is within 0.005 per cent, that is between 50 cycles and 20,000 cycles, depending upon the carrier frequency. The monitor also tests, not of course, in conjunction with airport transmitters and in any ground installation where the frequency accuracy may be incorporated as an integral part of the transmitter installation.

## Low-Cost

Two-Way System weighs 23 lb. and sells for less than \$200

AN RACAL Instruments Co., 6214 West 10th St., Chicago has recently added to their line of light weight and low-cost aircraft radio equipment a 10-watt transmitter and a basic receiver mounted in companion case.



Racal Aircraft radio transmitter and receiver

The two units together weigh 25 lb. including the power supply.

The transmitter has 14 built-in crystal-controlled outputs, designed to be operated at 3100 kc. and at any other single frequency between 2000 and 6000 kc. A tapped antenna coil is used for adjusting the output at other frequency. Switching from one crystal to another is accomplished by a single switch. An arbitrary volume control is included in the microphone circuit. The power supply may be operated from 6- or 12-volt battery with 10 amp. input at 6 volts and 5 amp. at 12 volts. A voltmeter power supply is used. The standby current is 20 per cent of the full load current.

The receiver is a five-band unit, covering a range from 205 to 405 kc. provided with sensitivity and volume controls. The dial is color-coded in kilocycles. Power for the receiver is obtained from a vibrator converting 115 amp. at 6 volts or 11 amp. at 12 volts. The unit can 11 in high (including the power supply) and 10 1/2 in. horizontally. Price of the transmitter is \$99, of the receiver \$75.

## Battery Operated

Portable Transmitter and Receiver Do Not Depend on Power Supply of Plane

EXTRAORDINARY LIGHT for small planes, such as the Taylor Cub, which do not have auxiliary power supply, is the new transmitter-receiver combination announced by the Avroport Co. of Ill., 2 E. N. Y. The new equipment is known as the Avroport weight radio transmitter and receiver, and is completely dry battery operated. It is claimed that normal operating currents about one year's life from the batteries. The transmitter is a crystal controlled medium amplitude type and can be modulated 100 per cent. The transmitter utilizes filament type tubes which last up about 1000 hours. It is thus possible to extend the filament life directly from the push-to-talk plug on the microphone which term in both filament and plate supply simultaneously. This arrangement eliminates the necessity of standby power, and makes for long battery life. The transmitter is designed to operate with 100 cc. and is supplied with a circuit for this frequency. The transmitter is extremely light, weighing only 3 1/2 lb., and is supplied with a push-to-talk plug 10 in. dia.

very box, with a complete complement of batteries weighs 3 lb.

The receiver, which filament type filament type low-current tubes, has two frequency ranges, from 380 to 420 kc. for beacon and weather signals, and from 3000 to 4000 kc. for local ship-to-ship communications. Sensitivity of the receiver is such that radio range between stations may be received at a distance of 100 miles. The transmitter, when operated with a fixed antenna has a range of 15 to 20 miles, but this may be extended to about 20 miles by the use of a trailing antenna. The entire equipment weighs less than 20 lb. and sells complete (both transmitter and receiver) for \$135.

## Fairchild D-4

Get CAATC Approval After Extensive Tests. Unusual Frequency Indicator Employed

A NEW UNIT of the Fairchild Radio Company, Type C-6 has recently been awarded the CAATC Test Certificate (No. 321). The unit covers the band used only from 150 to 415 kc. and is suitable for visual selection, semi-automatic selection, or for use as a beacon receiver. The receiver control and present a very neat appearance, and is designed for easy operation. Tuning is accomplished through a control, geared to a flexible shaft leading to the receiver and to the frequency radio side. The latter indicator takes the form of a "semimotor" type counter with large figures. Only the frequency marker the tuned frequency, to the nearest kilocycle, appears on the dial. Other controls are provided for increasing the audio and radio sensitivity, for switching from a-v-c to manual gain control, and for switching from loop to compensating antenna, necessary for most indicators. The



Control panel of new Fairchild D-4

entire compass equipment consists of the receiver proper, a power junction box, the remote control unit (see illustration), the manual indicator, a remote rotating control which controls the loop, and the loop itself mounted within a streamlined housing.

## Trans-Atlantic

British Imperial Airways Installs New Radio Equipment for Trans-Oceanic Service

WORK HAS COME from the Imperial Airways that standard radio installations have been decided upon for the Empire flying boats in preparation for regular Trans-Atlantic service. The Radio Company of Great Britain has installed two-way communication an antenna and also wires as well as equipment for direction finding and bearing lights. Aircraft direction finding stations will be located at both ends of the Atlantic to determine the position of the aircraft and to transmit bearings to the ships during flight.

An auxiliary radio equipment which is extremely compact and light in weight has been produced by the Radio Company for use on the flying boats. This equipment is known as the Hercules two-transmitter type 106-B1 and consists of a transmitter, receiver, and dynamo power supply housed in a single casing and weighing complete 45 lb. The dimensions of the case are 20x20x10 in.



Transmitter for transoceanic auxiliary service

The output of the receiver is of dual type, either for low resistance headphones or a loudspeaker. The output of the transmitter is 15 to 20 watts, obtained from an output of 40 to 50 watts. Power is supplied by dynamo operated directly from the battery supply of the day.



Wireless Electric Communication system at North Company, used for safety during bad weather



# BUYER'S LOG BOOK

What's New in Accessories, Materials, Supplies, and Equipment

A small pneumatic scribe of revolutionary design has been introduced by the Bostage Portable Tool Company, of Dayton, Ohio. Working only two pounds, and consuming but five cubic feet of air per minute, the Bostage scribe has a cutting speed up to 100 feet per minute in 15-gauge aluminum. It is capable of cutting shapes in panels at sheet-metal without breakage from the edge of the sheet. It consists of a stamped tool making a punch and the work can be turned in a mill or on a lathe, the scribe having serving as a lead grip. The scribe operates at 2500 strokes per minute and leaves an exceptionally smooth edge requiring little further attention. To cut out any internal shape it is necessary only to drill a small hole into the work in diameter, through which the head of the tool is inserted. After being started at this hole the scribe is pushed in any desired direction by the operator, following either line or template. Forward pressure required is very slight.—*Aviation*, May, 1939.

A handy time saver that gives correct size of tap drills for the U. S. gauges, together with a decimal equivalent chart is now being distributed free of charge by the Dupont Aircraft Manufacturing Company, of Minneapolis, Minn. On the reverse side there is listed the tap drill sizes of National coarse machine screws and National fine machine screws, together with a complete listing of tap drill sizes for the Standard pipe thread standards. Printed on a grooved and air resistant card, this little device should be handy in every aircraft shop.—*Aviation*, May, 1939.

Designed for larger aircraft, the aircraft division of the Public Binding Company has announced two new series of extra heavy capacity type borings made in ranges adaptable to all modern large airplanes. Designed the R12 and R22 series, these borings are pre-packed with lubricant and are highly corrosion resistant. R12 is of single row and R22 of double row design. Another new series of ball bearings is the R32, designed primarily for engine applications requiring bearings with self-lubricated balls and a high degree of load capacity.—*Aviation*, May, 1939.

Multiple conductor cables specially designed for aircraft for use with instruments, control devices, multiple light systems, switching apparatus or any interconnecting multiple circuits, are being made by the Boston Insulated Wire & Cable Co. of Boston, Mass. These are made with an outside cotton covering, designed for use in conduit or with a rubber sheath for protection from moisture and abrasion. Tinned copper shielding may be furnished on certain individual wires, or certain pairs of wires, over the outside cotton braid covering, under or over the rubber sheath. The number of conductors may be from 2 up to 30, each under shield.

The Boston aircraft spark plug is now on the market with a strong array of desirable features. It is internationally distributed by the G. E. Whitney Corporation, and manufactured by the oldest U. S. maker of spark plug plugs. The Boston plug uses the spark plug electrode design for long wear and simplicity of adjustment. The assembled plug is made in two parts, and the shielded plug in three parts, and replacements may be made on each of any of these parts. Standardized parts make stocking Boston spark plugs extremely simple.—*Aviation*, May, 1939.

Two torque indicating wrenches have reached the market recently in response to the widely recognized need for greater uniformity of nut and head strength. The No. 35 Bostage torque indicating wrench is offered as a popular model by the Bostage Filter & Tool Works of Allentown, Penna. It weighs 2 lb., has an overall length of 23 in., and is equipped with 1 in. square adjuster. An extremely calibrated scale is located on the shaft near the handle grip, reading from 0 to 200 ft. lb. Displacement of the pointer is accomplished by the movement of the spring steel handle. A sound ratchet feature is incorporated in the design, intended to prevent over-tightening. The J. T. Williams & Co., of New York City. This wrench gives a sharp sound signal for any



Bostage Scribe



Boston Insulated Wire



Table series 32 and 35 torques



RCA electronic engine-inform unit



Bostage 3520 test press



desired torque from 30 to 200 foot pounds in five setting the usual scale. A light reading scale is also provided for visual check on pressure. This wrench is 7 1/2 in. long and is equipped with a copper head which can use any socket having 1 in. drive opening. It is known as the Williams torque Wrenchmark No. 5-57.—*Aviation*, May, 1939.

RCA research laboratories have produced an electronically operated engine-inform diagnostic equipment for accurate and dependable measurement of rapidly changing cylinder pressures. The RCA and electronic instruments due in time and marks of mechanical instruments. It is composed of a pressure unit of revolutionary design, a crude ray oscillograph, an amplifier, and a read-out unit. The pressure unit, unaffected by temperatures up to 250 deg. Centigrade, is built to withstand pressures to 5000 lb., and converts rapidly changing pressure into electrical signals which are amplified and put out on the screen of a cathode-ray tube. Accuracy of the unit is extremely high for engine speeds over 1800 r.p.m. Features claimed for this equipment include easy timing to pressure curves of any form of dynamic pressure; simple and accurate indication of any point on the diagram with respect to the crankshaft angle; simple electrical calibration of pressure at any point in the pressure diagram; and flexibility of the system, permitting detailed study of any portion of the cycle.—*Aviation*, May, 1939.

Its hydraulic press designed for aircraft press work have recently been delivered by the Bostage plant of the Bostage-Standard Corporation. Three of the presses are of 280-ton capacity, and three are of 200-ton capacity. Following last operation of the moving plates to and from the work, both presses are of the double action type, actuated by rotary oil pump, electrically driven. The 280-ton presses have a plate 60 by 65 in. and a stroke of 24 in. The 200-ton presses have a stroke of 44 in. and a table 80 in. wide and 120 in. between side bearings.—*Aviation*, May, 1939.

A two cylinder hydraulic press is offered to the aviation industry by the Eastmanning and Research Corp., of New York, Maryland. It is designed to form sheet metal by forcing a wood or metal plate to spread into the work, while two edges are contained with clamps. The capacity of the machine is 150 tons, sufficient to form 1/16 in. thick sheets of iron or mild steel 60 in. wide, or a total of over 6 ft. x 10 ft., which can be handled in lighter material. Another new product offered by the same firm, and one of wide application in aircraft metal forming problems, is the EDCO sheet metal stretcher. This machine consists of two sets of pins which grip the work and then are drawn together to stretch the metal between them. The effect is the reverse of stretching metal with a bending hammer. With this machine it is possible to bend angles in sheets with the leg on the inside, or to form double corners similar to that done on a bending hammer, but with higher crowned shoulders.—*Aviation*, May, 1939.



Info 116 for EDCO Press

Info: EDCO Sheet Metal Stretcher









- Improved accuracy with decreased size and weight
- Fast vapors completely isolated in a sealed chamber
- Rugged jeweled mesh atom and powerful thoroughly researched diaphragm
- Completely accessible for maintenance inspection
- Entire mechanism outside of pressure chamber
- Case and ventilation completely ventilated through an air filter
- An adaptation of a mechanism proved through years of service in Pioneer Astmays Remote Inflowing Instruments
- Continuous mechanical lock-free from diaphragm to pointer

### French Boost Production With Foreign Engine

[illegible]

### Trans-Asia Line in Quick Stop, Japs in Pacific

nally started a Tokushima-Sanyo-Toei line steaming 2,400 miles down to Osaka, to her mandated Pacific Islands. Without any assistance I

other Pacific lines, this is an outstanding route in commercial waters, and it's not likely, for military reasons, that any connection will be severed.

**FAST TRACKER:** The Miles Master advanced training plane, now in heavy production for the RAF, has a top speed of 270 mph. It is powered with the Rolls-Royce Kestrel ARK with a maximum rated output of 715 hp. The two-plane aircraft has strong "business over" strings.

A black and white photograph of a biplane flying through a cloudy sky. The plane is seen from a side-on perspective, angled slightly upwards. It has two sets of wings, a single propeller at the front, and a tail section with a vertical stabilizer. The background consists of a bright sky with scattered, dark clouds.

**TWIN-ENGINE FIGHTER:** A new French prototype of striking interest because of its resemblance to American thinking along blower lines, the Polaris-80 mounts two 670-hp Hispano-Suiza engines. Climb is 4,000 meters-8 minutes! Top speed—750meters around 800 mph!

**ADONISER FRENCHMAN:** One of the newer Buick products, this single-seater is powered with a Cosmo and Alfa 180 hp engine. It was reported to do "something around five miles a minute". Purchases of big torque engines should boost French performance as well as production.

# AMERICAN AIRCRAFT Zooms Ahead



... as stainless steel provides the newest forward step to speed, safety, lightness

**I**NDIVIDUAL engineers agree that American engineers lead the world in safety and maneuverability. Responsible for this leadership are first the one factor: the aggressive, unshakable policies of our designers and builders.

The thoughtfulness, foresight, ingenuity, which we employ in the design of our aircraft is the lead. As soon as new materials and new methods are proved to be better, less costly, or generally more satisfactory, America will adopt them quickly and wholeheartedly.

Newest of forward steps toward improved aircraft is the adoption of Stainless Steel.

Here is a metal that offers four distinct advantages:

1. **Stainless Steel's** efficiency, because of its built-in resistance to strength-weight and modulus-weight ratios.
2. **Stainless Steel's** resistance to corrosion, because it is impervious to rust, and its high speed air-to-metal resistance.
3. **Stainless Steel's** ductility, because it requires no post-tensioning or bending to design the perfect desired form and finish.
4. **Stainless Steel's** resistance to fatigue, because it is resistant to stress, and its built-in resistance to corrosion.

Aircraft designers and builders have been quick to realize the significance of stainless steel, as an outstanding by which they can produce the finer ships now in demand. Write today for complete engineering data.



## UNITED STATES STEEL

AMERICAN STEEL & WIRE COMPANY, Cleveland, Chicago and New York  
CARNEGIE-ILLINOIS STEEL CORPORATION, Pittsburgh and Chicago

NATIONAL IRON COMPANY, Pittsburgh

California Steel Company and Phoenix Pacific Coast Distributors

Seattle Steel Products Company, Chicago, St. Louis, St. Paul, Minneapolis

United States Steel Products Company, New York, Boston, Philadelphia

## UNITED STATES STEEL

sort of flying machine. These American leaders emerged from Europe's bombers will wear the lead in Ireland and Newfoundland starting with weekly flights around New York.

It is a stand-out, the super-Kaiser, which will probably go north for the winter taking on the projected British Atlantic fleet.

Performance data on the big British battleships which show they are due to launch any day shows that the British won't be ready for real action, even for a long time. With a full-air range of 1000 miles and a cruising speed of 100 mph, they played a major role. A first-class crew is in the other ship that they're intended for, and they'll be ready to go. The British have a big boat very far along now on paper that can fly for 1000 miles and a full transatlantic fleet, they're keeping the British flying.

The French problem is just the other way around. They're coming along slowly in some respects but in many others they're not. The French don't deny that their efforts will be long and hard in the case with many flights and not to run in error.

The French have been supplied with supplies from the United States by shipping French ships to the United States. The French have been supplied with supplies from the United States by shipping French ships to the United States. The French have been supplied with supplies from the United States by shipping French ships to the United States.

## AS OTHERS FLY IT

### Gulls to Survey Backway Route

The long way around may sometimes be best, and for most mail the British have had their eyes on a route nearly all-British route to Australia across the Indian Ocean from Africa, dodging the Red Sea and India as possible trouble spots. They're finally not coming to any other place but Australia has shattered Dr. Archibald's Concluded that Gulls to survey the route this summer. It will go from Australia to Korea, the Ganges, China, and Seychelles Islands, a total of 4,000 miles.

A French aviation partnership has been broken up by the death of Jacques Hergott, who came from the United States in 1918 and had been associated with his brother Louis. The French partnership, which was in the United States after its other plane had been withdrawn, has just taken over the Lafayette company on the assumption because of illness of another French partner, Pierre Lelander.

A series of Gulls is to come from England—something like it has been expected ever since the Civil Air Guard started flying. One of the most justified fears of the Gulls is that it would produce a sort of half French plane which would be less so in an emergency than a one for another with more experience. Now that 1,200 are in training, the Air Ministry has decided to order the Gulls from Italy to fly into the U.S.A. in case of war and give them advanced training, while the rest will be conscripted to undertake other forms of national service. At that, the designations of the Gulls is offering insurance to everyone who wants to buy, lease, or lease has turned up some Italy U.S.A. material that hasn't been approved by previous design.

The absolute speed record is in for a tough summer if the British and French get anywhere with the ships they are building to prove it a looking. Lord Rufford is making one expected to do 100 mph—about of their house on it. It that it will have a British engine, probably the new high speed one of which there have been rumors for some time. The British have been building a new ship, the Gulls, on the medium engine, little ship formula—a Canadian motor with an 800 hp. British engine. The ship is a sort of success in the Canadian Corps, and the Gulls is derived from the Canadian C-112 built for a record attempt in 1930.

Prize number this month is the British that did 100 mph at 121 mph with 4410 pounds, 80 mph over the Italian record. It's a pretty big deal, and it's a pretty big deal. The British have been building a new ship, the Gulls, on the medium engine, little ship formula—a Canadian motor with an 800 hp. British engine. The ship is a sort of success in the Canadian Corps, and the Gulls is derived from the Canadian C-112 built for a record attempt in 1930.

The Canadian aviation report, showing the Gulls and crew of any type the slowest of judgment in Canada and their flight after bad weather forced up, has been pretty well taken at its face value in England—as it perhaps should be. American criticism of the incident is discussed as further evidence of British.

Now you heard about "Chinese shipbuilding"? Like all these old "Chinese building" and "Chinese building" expressions that grew up in the past few days, which is the one that is the direct opposite of reality. It seems that in War Two China, especially after the Japanese attack, the Chinese National Government and a couple of British planes, it showed on the officials in charge of Chinese that a good start day was the worst possible condition for a flight which happened to make it impossible. So now they don't give their plane the best start day, but they give them a pretty low and the reality very much better. What a pitiful job!



THE BRITISH DO LEARN. The above industrial building for the design is as up to date as the best Pan American apparatus—probably inspired by it.



DO THEY? Photo shows one of the "battering" impact! will was to reflect their true attitude, going ahead ship for the British's Camp Base, Newfoundland.



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### Martin Adds A Wing Doubles plant capacity in 11-week project

By the time this issue reaches our readers it is probable that the Glenn L. Martin Company will have completed and super-erected factory with a total floor area of 3,367,000 square ft., with employment facilities for 18,000 workers. Already the total number of employees in the Martin payroll has gained 50 per cent since January 1 to reach a new high level of 5,514, making Martin the second largest employer of labor in the City of Baltimore. By the end of the current year, President Martin estimates that the 15,000 figure will be closely approached. The company now has a backlog of unfilled orders in excess of \$22,000,000. The next opportunities recent order on the company's books was one for 100 of its new two-engine bombers, placed by the French Government.

At a recent meeting, the following officers were elected for the current year: Glenn L. Martin, president; J. T. Harrison, executive vice president; R. F. Taylor and R. C. Scullion, vice presidents; Thomas H. Jones, secretary; M. C. Beck, treasurer; and assistant secretary, M. R. Schermerhorn, assistant treasurer. All of the officers, with the excep-

tion of Mr. Schermerhorn, were re-elected as directors, as well as Edward Evans, John W. Guelon, and W. A. Crampton.

### Lockheed Climbing Payroll at 5,300; new models planned

Employment figures at the Lockheed Aircraft Corp. plant have been climbing up this year for the second time in Los Angeles. The payroll on a maximum day labor check, we had heard to the membership of 5,338 employees on the payroll, an all time high for the Lockheed plant, and company with 5,800 as of January 1. Meanwhile the delivery stage-up and the British bombers are being set just about on schedule, along with other planes for the Dutch East Indies, and anti-submarine warfare and other missions. Current forecast deliveries include a "14" for Finland, and an "Elastic" for America, Bulgaria.

In his annual report to stockholders, issued March 11, Robert E. Davis, president, stated 1939 sales at \$20,214,000, nearly double 1937 sales of \$9,896,044. For the fiscal year ended Dec. 31, 1939, net profits were \$448,151. Davis predicted that Lockheed would reach the highest production rate in its history within a few more months. The production has been based on rumors that Army orders will be placed for the P-37C type which recently made a successful transatlantic flight. Davis indicated that the Lockheed Company is pushing engineering work on a new standard air line of medium size and high speed, in a known tendency as the "Kassidy".

### United Expands

Names officers for new  
Vought-Sikorsky Div.

Most details of United Aircraft Corporation's expansion plans (Aviation, March 1939, p. 5) indicate that much of the new construction will be devoted to expansion of engineering and laboratory facilities. To the Pratt & Whitney plant in East Hartford will be added a third floor, with a four-story of about 14,000 sq. ft. This will be of brick and steel construction with improved lighting, an automatically treated ceiling, and a ventil-



MARTIN'S MASTERPIECE: As we went to press, this was the most recent available view of the Glenn L. Martin factory and its huge new addition, now rising in the background. By the time you see it it will be as complete as a triplane.

As shown here, the new "jet assembly" will have two floors, each 280,000 sq. ft. in area. With \$22,000,000 worth of added orders in the books, Martin will be able to add forty full 100-



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strong system. To the rear of the factory will be erected a new engine test house into four test chambers capable of testing engines up to 3,000 hp. Two test buildings will be used for experimental dynamometer testing of engines and for a few months of workover testing. Half the floor space of the Research Building will be used for the Pratt & Whitney division will expand, will be occupied by an experimental machine shop and assembly department, and a technical and physical testing laboratory. Two additions will be made to the Research Building. The first addition, which will serve as the new Chester Wright plant, to add about 75,000 sq. ft. to the plant area. The new Research will also consist of one propeller test house, with four test chambers, accommodating propellers up to 96 in. The second addition, which will house the Chester Wright and Sikorsky divisions, will have the area of its engineering building increased by 6,000 sq. ft., and an addition made to the north side of the factory building of 450 x 150 feet. A refinery will be incorporated from the plant to Illinois Airport. The entire program is scheduled for completion by July 1.

Effective April 1 the two Fafnir manufacturing divisions were recombined into a single unit known as Fafnir-Bendix Aircraft. Kenneth W. Clark, Vice-President of United Aircraft

Corporation, is General Manager of the new Fafnir-Bendix Aircraft division. Other division executives are as follows: Charles J. McCarthy, Assistant General Manager; John J. Sullivan, Engineering Manager; Fred Sawyer, Superintendant; Edward W. Thompson, Sales Manager; Rex E. Bond, Chief Engineer; Michael Gubinski, Chief of Design and Aerodynamics; George Mulvane, Executive Engineer; E. H. Gentry, Asst. Treasurer, Asst. Secretary and Division Administrator; F. F. Conner, Asst. Secretary and Auditor.

### Howard to Build

Chicago plant to have plane-ready output

ED DE WISSE, vice-president and general manager of Howard Aircraft Corporation, announced that a \$100,000 plant, with an annual capacity of approximately 300 planes valued at about \$1,000,000, will be built in Chicago. Manufacturers are under way by which the plant will be erected by other interests and leased to Howard for a long term of years. Howard's present production is about four personal craft per plane a month, but he is now doing an initial capacity of one plane of the type every working day is anticipated, and the company expects to be in



JOHN C. DE CLARK, Vice-President of United Aircraft Corporation, is General Manager of the new Fafnir-Bendix Aircraft division. Other division executives are as follows: Charles J. McCarthy, Assistant General Manager; John J. Sullivan, Engineering Manager; Fred Sawyer, Superintendant; Edward W. Thompson, Sales Manager; Rex E. Bond, Chief Engineer; Michael Gubinski, Chief of Design and Aerodynamics; George Mulvane, Executive Engineer; E. H. Gentry, Asst. Treasurer, Asst. Secretary and Division Administrator; F. F. Conner, Asst. Secretary and Auditor.

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## The Test Pilot Looks at Aircraft Safety

(Continued from page 22)

The necessity to use lateral control with engine sliding through the center of the rotor is to be hazardous and is considered dangerous. The demands on the rotor caused by the conventional loading gear and the steering and spinning possibilities, coupled with its partial blanketing by wings, landing gear, and flap, produce a control which is extremely and dangerously normal flight. Slipping and skidding can be the source of great trouble. Well-balanced designers will avoid control tail or the effort there should be made early possible the complete stalling of the vertical tail and the reversal of rotor forces.

The design of such a spinning can be further approached when it is realized that changes in yaw are usually accompanied by large changes in pitch. One must not lose sight of the fact that to be able to the most thing must be inherently safe. Directional control should not be placed at these changes. Arrangements can be eliminated as unnecessary. Slipping and skidding to any but a very slight degree are unnecessary for normal flying and maneuvering. The large normal lifting force serving as a wing, if reduced totally, has a component will enable to produce the turning that is necessary for normal flight. The requirements for rotor control can and should be reduced to that of a steering but according to torque variations due to power and speed changes. Supply all the control necessary, but no more! For obvious reasons the use of the bicycle landing gear and direction of the stick and improved stability in flight, will do much to assist the accomplishment of such a simplification.

In the case of a multiblade airplane, the rotor blades on a somewhat different aspect because of the possibility to encounter asymmetrically applied thrust. The magnitude of the control required to overcome adverse yaw is a minor factor. It is true that directional training for various conditions of power and forward speed is required, but the demands for this effect are small. In the case of the multiblade airplane, with regard to the possibility of engine failure, it is generally agreed that sufficient rotor must exist within the capacities of the pilot to apply it to compensate for the

uncompensated thrust which remains. It is believed, however, that more compensation should be given to the design of the fixed directional stability independent of the rotor control so that the demands on the rotor are decreased when such a condition occurs. That the possibility of violent landing actions be reduced.

Present designs seem to be based on the requirement that the pilot make a control decision immediately as engine failure with little consideration as to what actions should be taken to do so. It can easily be seen that such human falling can occur under the stress of conditions such as a take-off at angle in bad weather, with the added disadvantages of returning landing gear, advancing power, and maneuvering other instruments. The design suggested would lead to a decrease in the rate and magnitude of the dynamic motion resulting from engine failure causing a violent change in heading and making downward due to the shift, which seems to be the cause of many accidents. It is expected no small part of the pilot and too little of the failure to support continued demands on the part of the pilot to avoid disaster in the case of engine failure in multiblade airplanes. There is no reason to believe that an airplane could not be designed in which, when an engine fails, the airplane would yaw slightly and slowly and continue generally on its way without further disturbance, even though slightly tilted laterally and possessing a slight stall.

Under such flight conditions of smooth air and good visibility, the requirements for lateral control and visibility are small. The more can be not for a bicycle. But did anyone ever try a glider on a rough surface and without spare resources? Lack of attention shows the immediate handling of a versus cyclic loading is disastrous.

It does not seem unreasonable to expect that as the use of an engine the design be so arranged that the wings would not only tend to, but to their own weight, maintain level lift control, as designs now require some dihedral effect, some correct roll due to yaw. And all have some degree of dihedral stability. But the proper conclusion of these qualities in such

a way that, with a relatively no attention in the part of the operator, the airplane will always wander along on a nearly straight or series of straight flight paths and always right-side up a nearly unassisted. Speed stability does not exist, not that it is undesirable, simply that it is not required. It seems necessary in the interests of safety. This does not mean that representation for some with relatively means (dihedral) has not been observed to be unfavorable. It does mean that both adverse are undesirable and the design means should be sought. Whether the vertical tail seen required to meet this condition would conflict with the thoughtless wandering along, as the rotor is uncertain at present. However, it should be possible to so simplify the airplane that the situation of the pilot is merely required to supply geographic direction sense.

The presence of violent lateral instability at low speeds is most all types is associated with and disconnected to connection with the stall.

Stability in the form of an automatic pilot is not done. It is in more cases desirable, but subjected to the same requirements as is the human pilot. Designers should not rely too heavily on its capabilities but should build a higher degree of inherent stability into their design. Too much is at stake in the event of failure.

### Longitudinal Control and Stability

elevator controls occupy a position somewhat similar to that of the rotor in that they, too, are usually more powerful than desired. Extreme changes in center of gravity, power, and flap-throw requirements can cause large variations in the location of the elevator angle range needed for the specific condition. Thus, an excess is available in such and the small range is large. Again, there is evidence of small area changes leading in the direction of safety.

The elevator necessary for maneuvering are determined by their ability to produce the design normal load factors. In this respect, the inertia of the entire system plays an important part. Except under extreme conditions, no difficulty has been experienced in making pull-ups to prove the design load V-G diagram.

The use of the bicycle landing gear reduces to a minimum the landing requirements made of the elevator to get the full down. Such a condition frequently is met. The maximum speed attainable in the air is not

(Turn to page 22)



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(Continued from page 15)  
 clearance demanded of the operator or pilot vary inversely with the adverse safety in design, every effort must be put forth to improve basically the airplane itself by the acceptance of known and proved desirable characteristics. Safety in flight can only be achieved through the patient and per-

sistent application of the results of fundamental research.

Tests made to date on existing airplanes indicate that many reasonably desirable characteristics are not attainable, that present absence of due for the most part to performance compromise. Safety in flight can be greatly improved.

## Machine Shop at Vultee

(Continued from page 21)

A much smaller job presented a somewhat different problem. It was required to mill a rib of approximately 1/8 in. on a small curved-line hand-track fitting, making it necessary to rig up a rather bulky superstructure for attachment to a vertical mill. This supports a lower, the head of which carries a frame for supporting the work. The head of the arm is in turn retained in a slide fixture clamped to the mill table. Thus the table may be traversed backward and forward in the customary way in order to carry the work, or to swing something head support, past the vertical milling cutter at the required cut. This arrangement affords operation on the shoulder of the head-and-tail bracket is the third machine operation required. The first is a stroke-milling operation on the outer flange of the bracket. Then it is necessary to drill a number of small holes into each shoulder of the bracket, on each side of the outer flange. The third operation is the radial milling of the shoulder as described above. This bracket is also fixed on a shaper and drilled for attachment to the clevis of the plane.

Another example of the type of machining required for the Vultee aircraft bracket is that done on the superannuated control-pointing gear. This requires cutting in a hollow box of extremely irregular shape. Throughout the piece there are numerous other such boxes, as gear boxes, etc., but the control pedestal is the most complex. It carries multiple control levers for actuating the carburetor, throttle adjustment, propeller setting, flap extension, landing gear extension, etc. Machine work is done mostly in a lathe and includes boring, turning, and facing.

An excellent piece of precision milling and drilling is done on the wing casting used at the attachment point of the semi-section main wing

beam to the major fuselage bulkhead frame. This casting is very trouble making, the hole being cut narrower than the outer portion of the casting, which must fit between the great ends of the top and bottom air strips. The main body of the casting in this case is milled to take the bearing rings which are attached both to this casting and to the spar-up ground plate, which also should be milled. It is obvious that the drilling operation calls for precision bearings, at the ends of the casting, long through holes must pass through two flanges apart, both power plates of the top caps, and the closer main-plate proper. This drilling is done in a symmetrical job which is reversed to drill from both sides. Holes are then turned to close tolerance.

Another precision milling and drilling operation is that performed on the large aluminum-alloy castings used in attaching the landing gear to the main wing. As the gear must connect and extend, in addition to bearing the heavy loads of landing in rough fields, this part must be precision to very close tolerances, particularly with respect to parallel milling between these separate parts of steel and to the facing of bottom and top surfaces which control movement of the gear to the airplane structure. Sequence of operations first calls for precise milling between all four flanges or ears. The bottom faces are then finished and milled with reference to the finished surfaces of the ears. Thereafter it is relatively simple to finish and drill a set of 24 holes, some of which are angled holes and some of which are straight holes for machine screws.

Another interesting piece is a high degree of accuracy and assembled directly to the ears by means of long through holes accommodated at holes under the base in the upper and of the ears. Temporary

straps are used for this work, which is performed largely in a horizontal mill. The long hole is first bored and the ends of the long ears are then milled for center distance. The short hole is then bored and bored and the ends milled. A one block and bushing is used for drilling at approximately 1/2 in. to both ears, the tool used being a combined drill and boring cutter, which cuts on down and mills off the shoulder after driving the hole. This operation is performed from both sides of the casting to check alignment of the left hole and last both shoulders.

One of our important machining jobs is finishing the landing gear axle and also cylinder assembly. This is a single structural unit assembled from steel tubing and flat-plate steel, welded together. It is a single part to manufacture, even before machining, and is extremely important in the operation of the landing gear, as it carries the entire weight of the main wheels and provides for the shock-absorbing action, which helps smooth operation on rough fields. This part mounts vertically in the landing gear leg, which is in turn retained into the wing of the airplane. In operation the also cylinder slides up and down in the main support strut, being guided on slides by two Vee blocks. The wheel axle is disassembled at right angles to the also cylinder from a heavy support at the bottom of the unit. Machine operations include boring of both holes and milling the ears. The also cylinder is first rough bored with a gas drill mounted in a lathe, after which the end of the cylinder is turned and drilled on the outside diameter to take the parking collar. The cylinder is then turned with an adjustable reamer and bored to tolerance of 0.0013 in. The short axle-support hole is bored on a horizontal lathe, the setup providing for boring and turning the hole and turning the outside diameter of the axle tube to take a left grease connector, all with the same basic setup. Final operation is the milling of the two guide vee's with special cutters; this is done to close tolerances since the main screw is inserted by bearing vee blocks which act as sliding bearings for the landing gear vertical shock-absorber action. These bearing vee blocks are precision ground to a high degree of accuracy and assembled directly to the ears by means of long through holes accommodated at holes under the base in the upper and of the ears. Temporary



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## Stacks and Rings

(Continued from page 21)

collected in particular must be rugged and transfer fire to avoid any possibility of fire starting due to a failure in service. While both the heavier the gage of the material and the heavier the design the more resistant it will be to failure due to overheating, vibration, or corrosion. The problem involved is the design of a light and heat fire rugged enough to stand up in service.

The three collectors available and preferred for the design of exhaust collectors together with their relative weights are as follows:

Material	Weight (lb./sq. ft.)	Weight (lb./sq. ft.)
S.A.E. 402 Carbon Steel	3.45	101
303 Stainless Steel	7.35	201
304 Stainless Steel	8.12	220

The weight of standard size exhaust collector tubing in 100 inch lengths of each of these materials is given in Table I which was published in the first article of this series.

Experience has shown that these materials in 16, 19, and 20 gage are satisfactory in practically all installations. These gages correspond to 510 mil, 603 mil, and 635 mil respectively. 603 mil material is used for short exhaust stacks, or exhaust collectors for engines developing under 500 horsepower. In general the Army and Navy require exhaust collectors to be made of 642 mil material or heavier. In the large diameter tubing required for the latest high horsepower engines it is believed advisable to use 649 mil material.

The author has calculated the weight per horsepower of a large number of typical exhaust collectors. The average figures given below may be used for a preliminary estimate of the weight of an exhaust collector for a new design. For engines under 500 horsepower the average weight of exhaust collectors is 36 lb./hp. for engines over 500 horsepower the average weight is 642 lb./hp. Exhaust collectors for engines over 500 horsepower frequently incorporate intermitter tubes for preheating oil. This intermitter type exhaust averages 67 lb./hp. Exhaust collectors for two-row engines are slightly heavier than the foregoing averages due to the additional weight of the exhaust elbows leading from the larger number of cylinders. An average weight of 55 lb./hp. is con-

sistent for two-row exhaust collectors.

As engines reach and exceed the 500 horsepower stage the weight of the exhaust collector per horsepower decreases somewhat. This is due to the fact that the cross-sectional area of any section of a ring varies as the square of the diameter while its weight increases only in the first



Fig. 1 Standard type slip joint

Design shown subject of other than 100 inch length should be noted.

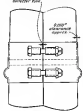


Fig. 2 Roller type slip joint

## Material

The number of materials suitable for use in exhaust collectors is limited by the severe requirements. A suitable material must retain a large measure of its strength at temperatures from 1200° F. to 1600° F. which is the normal operating temperature range of exhaust collectors. The material selected must neither lose its scale at these temperatures. Furthermore the material must be very corrosion resistant without excessive pitting or pitting since these factors will not stand up under the high temperatures encountered. To further aggravate this corrosion problem the oil and ash in the high octane gasoline used with high power engines is very corrosive when deposited by the exhaust gases on the inside of exhaust collector rings. After a material has passed the technical requirements it must still be commercially available at a reasonable price, relatively light in weight, and easily fabricated. This latter point is very important since collectors are normally constructed of numerous parts which are curved in one or more places.

The only materials currently available that satisfy the foregoing requirements in any extent are:

S.A.E. 402 3040 Carbon Steel  
303 Corrosion and Heat-Resisting Steel

General (Nickel-chromium-iron alloy)

S.A.E. 402 3040 Carbon Steel

This material is commercially available in the form of sheet or transfer tubing. Its chemical composition is as follows:

Carbon	0.25-0.35	Phosphorus (Max.)	0.015
Manganese	0.30-0.50	Sulfur (Max.)	0.010

(From S. page 21)

## NORTH AMERICAN AVIATION'S NA-49 "HARVARD" TRAINER



IS EQUIPPED WITH

## "NORMA-HOFFMANN" PRECISION BEARINGS

Recent large orders for these planes, for military service—more, for 400 units, being the largest production order for military aircraft placed in recent years—use a high tribute to the experience, skill, and record of the builders, North American Aviation, Inc., Longwood, Calif.

NORMA-HOFFMANN PRECISION BEARINGS are employed in the controls of the ships themselves, as well as in the Pratt and Whitney "3341" Wasp Engines which power them, and in the Kollsman Instruments that are a part of the instrument equipment.

Identified with the aircraft industry from its earliest days, NORMA-HOFFMANN pioneered many of the important bearing types now standard in aviation equipment. \* \* \* Today, practically every representative builder of aircraft, engines, instruments, and aircraft equipment—including the U. S. Government—employs NORMA-HOFFMANN PRECISION BEARINGS to ensure safety, friction-free operation, and long uninterrupted service.



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## Stacks and Rings

The physical properties of S.A.E. 1325 steel are:

Tensile Strength..... 110,000 P.S.I. Min.  
Yield Point..... 70,000 P.S.I. Min.  
Elongation..... 15%

This material can be readily fabricated and welded to any desired form. In short form it can be bent through 180° without cracking over a diameter equal to its own thickness. It welds readily with an arc oxy-acetylene flame.

This material has the disadvantage of being easily corroded when not protected by plating or paint. A number of test coating plants are on the market to protect this type material when used for exhaust stacks or collectors. These plants paint the collector surface for a time but the exhaust gases corrode the inside surfaces. Exhaust systems of this material are very unsatisfactory from a corrosion viewpoint when installed in engine using high octane gasoline containing ethyl lead.

S.A.E. 1325 mild carbon steel has been used for short exhaust stacks and collectors on low power engines. It has also been used for exhausts on engines developing less than a few horsepower. Its strength and ease of fabrication are important considerations in this type work.

### Heat Treatment and Heat Treating Data

This material is commercially available in the form of sheet, round bar, and welded tubing. There are several variations of this material depending on whether aluminum, titanium, or molybdenum is used as the stabilizing agent. The following chemical composition covers each of these variations:

Carbon.....	.15	Max.
Manganese.....	.60	Max.
Phosphorus.....	.015	Max.
Sulfur.....	.015	Max.
Aluminum.....	0.02-0.05	Max.
Titanium.....	0.02-0.05	Max.
Molybdenum.....	0.02	Max.

The titanium content must be approximately 3 times the Carbon content.

The physical properties of this material are:

Tensile Strength..... 110,000 P.S.I. Min.  
Yield Point..... 70,000 P.S.I. Min.  
Elongation..... 15%

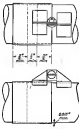


Fig. 1. Army type alloy steel

resists, and then allowing it to cool in still air.

The material welds beautifully with an arc oxy-acetylene torch. A slightly reducing flame should be used to create a porous weld. The material softens in the weld is subjected to temperatures within the 1500-1550° F. range and the type of intergranular corrosion which gives a corrosive leach mark. Within the temperature range from 300-2500° F. corrosion prevails as the grain boundaries and subsequently more cracks due to over-softening. The use of material with a low carbon content and containing one of the stabilizing elements such as aluminum, titanium, or molybdenum will avoid much of the intergranular corrosion and cracking. The type of stabilizing material must be used for satisfactory service since exhaust collectors are repeatedly heated to the embrittlement range.

To relieve distortion and welding stress and to stabilize the material adjacent to the weld it is essential that the finished collector be given a so-called stabilizing heat treatment. This stabilizing treatment consists in

heating to 1540-1600° F. for 4 hours followed by cooling in air. When the exhaust collector is heated to this temperature it becomes very plastic and such action must be independently supported to prevent distortion. If the furnace available is not capable of reaching 1500° F. an alternative stabilizing treatment consists in heating to 1575-1625° F. for 2 hours followed by cooling in air. The member has had considerable experience with exhaust collectors stabilized at these lower temperatures. They have had a uniformly successful service record free from cracks.

In order to clean up the collector after welding and heat treatment they should be given a light sand blast followed by pickling for one hour. The pickling solution should be a 10% solution by weight of hydrochloric acid and maintained at 50-140° F. After pickling the work must thoroughly rinsed in hot water to remove residual of the acid.

The final finish operation on a collector of corrosion resisting steel is passivating. Passivating consists of immersing the work for 30 minutes in a solution containing 30% nitric acid at a temperature between 120-150° F.

The material must then be washed thoroughly in warm water. Passivating accelerates the formation of a tough, passive oxide film on the surface of the material. It is this film that makes the material corrosion resistant.

The vast majority of present day exhaust collectors are manufactured of 18-8 corrosion and heat resisting steel. This material has an excellent service record and is easily fabricated in the field by hand.

This material is commercially available in the form of sheet, standard bar, and welded tubing. The material is used for carrying heat away from the exhaust to the cooling system because of its strength and reliability at high temperatures.

The average chemical composition of Inconel is:

Carbon.....	.05
Chromium.....	16
Nickel.....	70

The physical properties of Inconel are:

Tensile Strength..... 100,000 P.S.I. Min.  
Yield Point..... 80,000 P.S.I. Min.  
Elongation..... 10%

Inconel has the property of retaining high strength at elevated temperatures. It has an ultimate tensile strength of about 90,000 lb./sq. in.

(Continued on page 16)

# EXPERIENCE

## MILITARY

Vultee Aircraft  
U.S. Army Air Corps  
Vultee Aircraft Bombers  
Climax  
Pittsburgh  
Turkey  
Brazil

## AIRLINES

Vultee V1-A Transport  
Cathay Pacific  
1934-1937  
American  
Airlines  
1934-1938

## PRIVATE

Many Vultee V1-A  
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Record, Los Angeles to New  
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## VULTEE AIRCRAFT

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DOWNEY, CALIFORNIA, U.S.A. CABLE ADDRESS "VULTEE"



## The Unitwin Vega

(Continued from page 32)

### Single engine performance

The drag of a two-engine airplane operating on one engine is greater than in normal flight due to the drag of the dead-engine propeller, and the drag caused by attitude of the airplane and control displacement necessary to offset asymmetric thrust and lift. These effects will require approximately 30 hp for a plane of Type B. This is small compared with total power available, but is important in its effect on climb and ceiling. For example, the rate of climb of a 6000 lb. airplane operating on 300 hp will be reduced by 145 ft. per minute or approximately 30 per cent. The single-engine ceiling will be reduced to the order of 20 per cent. This deficiency is entirely eliminated with Type A, since, with Unitwin props there are no adverse thrust or drag factors in event of failure of a single engine, but merely a reduction in total power available, and a slight reduction in efficiency of the single propeller of constant speed type due to the new operating condition.

### Noise level in cabin

The sound intensity of a propeller is greatest at the place thereof, decreasing to a minimum at points along the thrust line. Therefore, the noise from the propeller mounted on the wing will seem less intense to occupants of the cabin than will the noise from propellers operating alongside the cabin.

### Weight comparison:

The weights of powerplant installations for airplanes of Types A and B are approximately as follows, assuming that both types are powered engines and are equipped with constant speed propellers.

Type A (Continued) — 1125 lb.  
Type B (2 engines) — 1850 lb.  
With the Unitwin Vega, if an engine fails at any time in flight the airplane continues to fly in normal fashion at reduced power. The constant speed propeller automatically adds the pitch most efficient for the new condition and the pilot is able to proceed to his destination, or to a precautionary landing, without exercise of manual skill. Since the Unitwin reflects the pitch of many pro-



J. CARLIN STEVENS  
Vice Department, Vega Airplane Co.

Length —	26 ft. 5 1/2 in.	25 ft. 6 in.
Span —	41 ft.	41 ft. 5 1/2 in.
Height —	4 ft. 5 in.	4 ft. 5 in.
Wing Area —	275 sq. ft.	271 sq. ft.
Wing Loading —	2,000 lb.	2,100 lb.
Empty Weight —	1,125 lb.	1,200 lb.
Gross Weight —	2,210 lb.	2,300 lb.
Powerplant Rating —	350 h.p.	350 h.p.
Full Cruise Speed —	217 ft.	217 ft.
Take off Run at Sea Level —	600 ft.	600 ft.
Landing Speed at Sea Level —	55 mph.	55 mph.
Maximum Climb at Sea Level —	1,200 ft./min.	1,200 ft./min.
Altitude Ceiling —	13,000 ft.	13,000 ft.
Service Ceiling —	11,000 ft.	11,000 ft.
Range —	710 mi.	710 mi.
Maximum Speed at Sea Level —	195 mph.	195 mph.
at 7,000 ft. (1,700 m.) —	185 mph.	185 mph.
Cruise Speed at Sea Level —	165 mph.	165 mph.
at 7,000 ft. (1,700 m.) —	155 mph.	155 mph.
at 12,000 ft. (3,660 m.) —	140 mph.	140 mph.

lous of airplane and powerplant control under single engine conditions, he is never late to devote himself to performance of procedure under such circumstances.

It may be noted that failure of the single propeller will subject the Unitwin powered airplane to complete loss of power. However, a study of airline experience shows that there has never been a fatal failure on a constant speed propeller. And propeller blades and operating mechanisms normally function without difficulty for a period many times greater than the normal operating life of an airplane, assumed to be 5000 hours.

Designed to carry five or six persons, the Vega will have a maximum speed of approximately 200 m.p.h. and will cruise at 160-180 m.p.h. for a distance of 570 miles. A trailing edge type flap is incorporated in the wing.

The landing gear is a solid axle tube frame from the region to the rear of the cabin, with the reference an unswayed wheel-shock bobbed to the frame. The two wing panels are bolted directly to the frame, eliminating a wing center section. The main engine will portion of the fuselage bolted to the frame at the rear of the main cabin. Although the landing gear rotates, the wheels extend sufficiently even in the retracted position, to present the structure of the airplane in event of a belly landing. The cabin interior depicts the finish of a large modern automobile. Free persons are accommodated in the privacy-once version, and are for loader while use. In addition to mail, express, and baggage.

Speedometer and estimated performance figures:

Take off Run at Sea Level —	600 ft.	600 ft.
Landing Speed at Sea Level —	55 mph.	55 mph.
Maximum Climb at Sea Level —	1,200 ft./min.	1,200 ft./min.
Altitude Ceiling —	13,000 ft.	13,000 ft.
Service Ceiling —	11,000 ft.	11,000 ft.
Range —	710 mi.	710 mi.
Maximum Speed at Sea Level —	195 mph.	195 mph.
at 7,000 ft. (1,700 m.) —	185 mph.	185 mph.
Cruise Speed at Sea Level —	165 mph.	165 mph.
at 7,000 ft. (1,700 m.) —	155 mph.	155 mph.
at 12,000 ft. (3,660 m.) —	140 mph.	140 mph.

Standard instrument equipment includes: Kollsman Compass, sensitive altimeter, corrected indicator, vertical speed indicator, bank and turn indicator, clock, manifold pressure gauges (2), engine exhaust gauge (2), thermometer (2), carburetor air temperature indicator (2), Waco anemometer, an electrically heated pitot tube, head temperature gauge and interior switch, hydraulic pressure gauge, landing gear and flap gear position indicators.

Electrical equipment includes: Exide battery, Edison generator, Edison pressure gauge, an instrument panel lights, 20 Green retractible landing gear.

(Turns to page 32)

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Close-up of the Automatic Direction Finder's Control Unit

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of Bendix Aviation Corporation  
401 Bendix Drive South Bend, Indiana, U. S. A.

AVIATION  
May 1934  
91

### The Unitwin Vega

(Continued from page 90)

lights, doors and baggage compartment latch, fuel pressure warning lights (2), set of Gritzer position lights, Western Electric master switch, Scintilla dual ignition switch, 2 30-watt lamps.

Power plant and accessories include: Unitwin Stromberg propeller, one Hamilton-Standard two-blade constant speed propeller, Hamilton-Standard control air, 2 Stromberg carburetors, 2 Eclipse electric starters, 2 Young oil temperature indicators, 2 Decca engine driven fuel pumps, Avroch Accessories fuel tank, complete lead to friction shafting, engine mounting, complete radio shafting, Eclipse landing gear oil pump, fuel system selector valve and control, fuel system air-line selector valve and control, fuel system tank selector valve and control.

### Sticks and Rings

(Continued from page 87)

at 1400° F. which is near the upper temperature limit of exhaust gases.

Internal lubricates and walls even more easily than 18-8 stainless oxidizing steel. It does not handle from cold working as rapidly as corrosion resisting steel. If necessary it can be softened by heating to 1500° F. for 15 minutes and quenching in air, water, or a dilute alcohol-water solution.

Stainless is not subject to embrittlement or intergranular corrosion as superheated with 35-6 corrosion resisting steel. In fact no heat treatment or finish of any kind is necessary after fabrication and welding. The weld is slightly more corrosion resistant than the parent metal. When annealed at 1600° F. 30 minutes inside forms on the surface. The weld can only be removed by grinding or pickling but will automatically reform on oxidant collector when heated. This coating does no harm and no effort is made to remove it.

Stainless is an excellent material for exhaust collectors but weights and costs more than 35-6 steel. It is probable that it will cost 35-6 steel for use on engines developing 1500 or more horsepower due to its greater strength at elevated temperatures and its superior corrosion resistance.

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# Continental ANNOUNCES THE NEW A-65 AIRCRAFT ENGINE



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140 lbs.

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